

HOME OF CLAMPING



2023/2024
SINGLE AND MULTIPLE
CLAMPING SYSTEMS

WE GENERATE EXCITEMENT.

Since the foundation of the company in 1890 until today the goal has remained the same: the highest quality in products and services. Nevertheless, the circumstances, tasks and challenges have changed, of course. By focussing on our core areas of expertise, we have long set new standards for innovative clamping technology - driven by our own development, the greatest possible flexibility and passion for individual solutions.

All this is only possible with committed and contented employees. Respectful interaction with others, personal development and measures for the wellbeing of each individual are therefore values that matter to us.



Company Management:
Wolfgang Balle, Johannes Maier (CEO), Jürgen Förster

OUR COMPANY HISTORY

- 1890 Company founded as a lock manufacturer by Andreas Maier.
- 1920 Product range extended to include spanners.
- 1928 Production line assembly of FELLBACH LOCKS.
- 1951 Introduces clamping elements and diversifies into workpiece and tool clamping technology.
- 1965 Toggle clamps extend the AMF product range, AMF catalogues are now printed in ten languages.
- 1975 Further specialisation into hydraulic clamping technology.
- 1982 Clamping and fixture systems round off AMF's clamping expertise.
- 1996 AMF team organisation in all sectors of the business, Quality management with certification to ISO 9001.
- 2001 AMF Service Guarantee for all products.
- 2004 Introduction of the ZPS zero-point clamping system.
- 2007 The magnetic clamping technology extends the AMF product range.
- 2009 Development and marketing of AMF Vacuum clamping technology.
- 2012 LOW-COST AUTOMATION gripping, clamping, marking and cleaning.
- 2014 AMF presents the most extensive product range of automation solution in zero-point clamping technology.
- 2017 Wireless sensing systems extend the expertise into Industry 4.0 and blends seamlessly into the AMF product range.

PLEDGES THAT COUNT IN EVERYDAY LIFE

For this reason, we have a few principles that we follow by conviction and which always apply.

INDIVIDUAL DEVELOPMENT

Even if the product you need does not even exist yet, we will find the right solution with you: from special designs to new developments, everything is possible.

WARRANTY

If, despite our high quality standard, there is a complaint, this is dealt with quickly and unbureaucratically, even beyond the warranty period.

HIGHEST QUALITY STANDARDS

Careful manufacturing based on tradition since 1890, and naturally with a modern quality management system according to ISO 9001 for many years.

SHORT DELIVERY TIME

With over 5,000 articles in our warehouse, you can expect your order to be dispatched on the same day.

COMPETENT SERVICE FROM EXPERTS

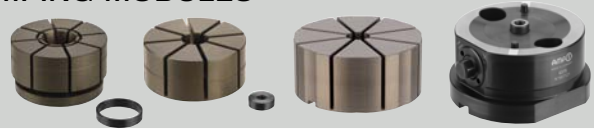
Your local retail partner or the specialists in our team will find the right solution for every task.

MADE IN GERMANY

Our entire product range is developed and manufactured exclusively by our employees in Germany.

**COLLET - MECHANICAL AND HYDRAULIC
COLLET ATTACHMENT FOR ZERO-POINT CLAMPING MODULES**

4 - 13



MULTIPLE CLAMPING SYSTEM „EASYWISE“

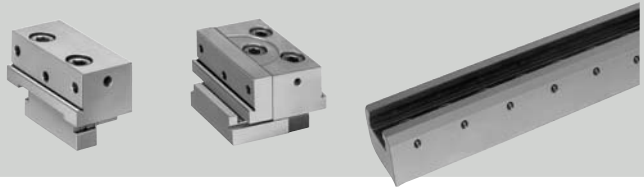
18 - 21

NEW!



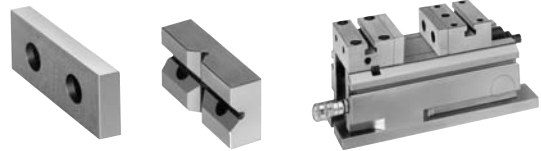
MULTIPLE CLAMPING SYSTEM NO. 6371

22 - 31



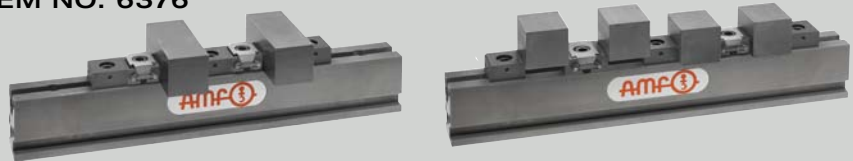
PNEUMATIC VICE

32 - 37



MULTIPLE CLAMPING SYSTEM NO. 6376

38 - 52



CHAIN CLAMPING SET

53 - 60



Subject to technical alterations.

No. 6375M

Mechanical collet - base element

Base element made of tempered steel, plasma-nitrided and burnished.

| Order no. | Size | Clamping stroke \varnothing [mm] | Tightening torque Md max. [Nm] | SW | dia. D | H | Weight [g] |
|-----------|------|---------------------------------------|-----------------------------------|----|--------|----|---------------|
| 567121 | 10 | 0,3 | 30 | 10 | 81 | 40 | 1259 |
| 567122 | 20 | 0,3 | 40 | 13 | 117 | 56 | 3633 |

Design:

The mechanism of the body is protected against dirt and cooling water. Surrounding clamping rim for fastening onto the machine table and flat surfaces for seating in the machine vice. Provided on the underside is the holder for the AMF zero-point system size 10 and size 20 as well as grooves for positioning on AMF zero-point clamping modules for indexing. The base element is used for seating the collet attachments for inside and outside clamping.

Advantage:

- The lateral actuation makes it possible to clamp workpieces with blind holes and through-holes
- Control display clamped/released by means of dowel pin on the base element
- Flexibility through a base element for outside or inside clamping

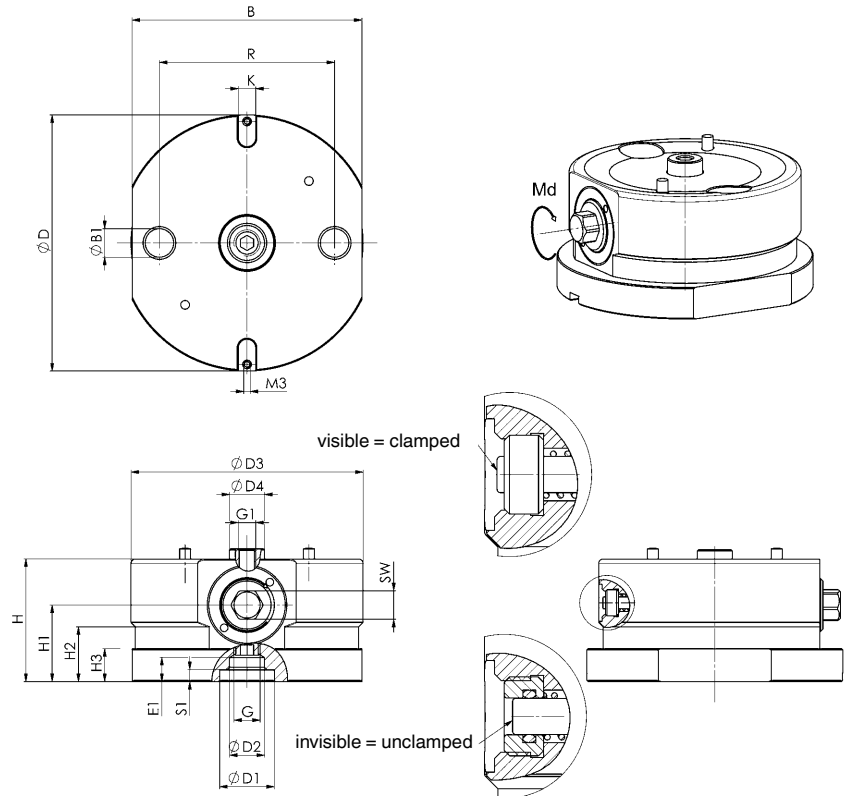
Note:

The collet attachments 6375ZA and 6375ZI must be fastened using the fastening kits 6375BA (outside clamping) or 6375BI (inside clamping).



Dimensions:

| Order no. | Size | B | B1 | dia. D1 | dia. D2 | dia. D3 | dia. D4 | E1 | G | G1 | H1 | H2 | H3 | K | R | S1 |
|-----------|------|-----|------|---------|---------|---------|---------|----|-----|----|----|----|----|---|----|-----|
| 567121 | 10 | 72 | 8,4 | 15 | - | 74 | 11 | - | M8 | M6 | 26 | 17 | 12 | 8 | 50 | 4,5 |
| 567122 | 20 | 105 | 13,0 | 25 | 16 | 106 | 16 | 11 | M12 | M8 | 35 | 25 | 15 | 8 | 80 | 5,5 |

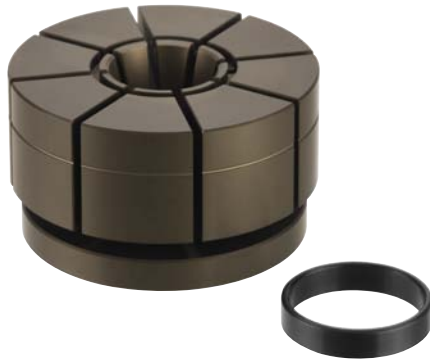


No. 6375ZI

Collet attachment inside clamping

Collet attachment made of high-strength aluminium, hard anodised. With circlip made of tempered steel, burnished.

NEW!



| Order no. | Size | dia. D | dia. D1 | dia. D2 | dia. D3 | H | H1 | H2 | H3 | H4 | Clamping stroke Ø [mm] | Weight [g] |
|-----------|------|--------|---------|---------|---------|------|----|----|------|-----|---------------------------|---------------|
| 567125 | 10 | 70 | 32,7 | 11,2 | 65 | 41,5 | 10 | 7 | 14,5 | 9,5 | 0,3 | 327 |
| 567126 | 20 | 99 | 44,7 | 16,0 | 90 | 46,5 | 10 | 10 | 14,5 | 9,5 | 0,3 | 779 |

Design:

Collet attachments are always supplied with circlip.

Application:

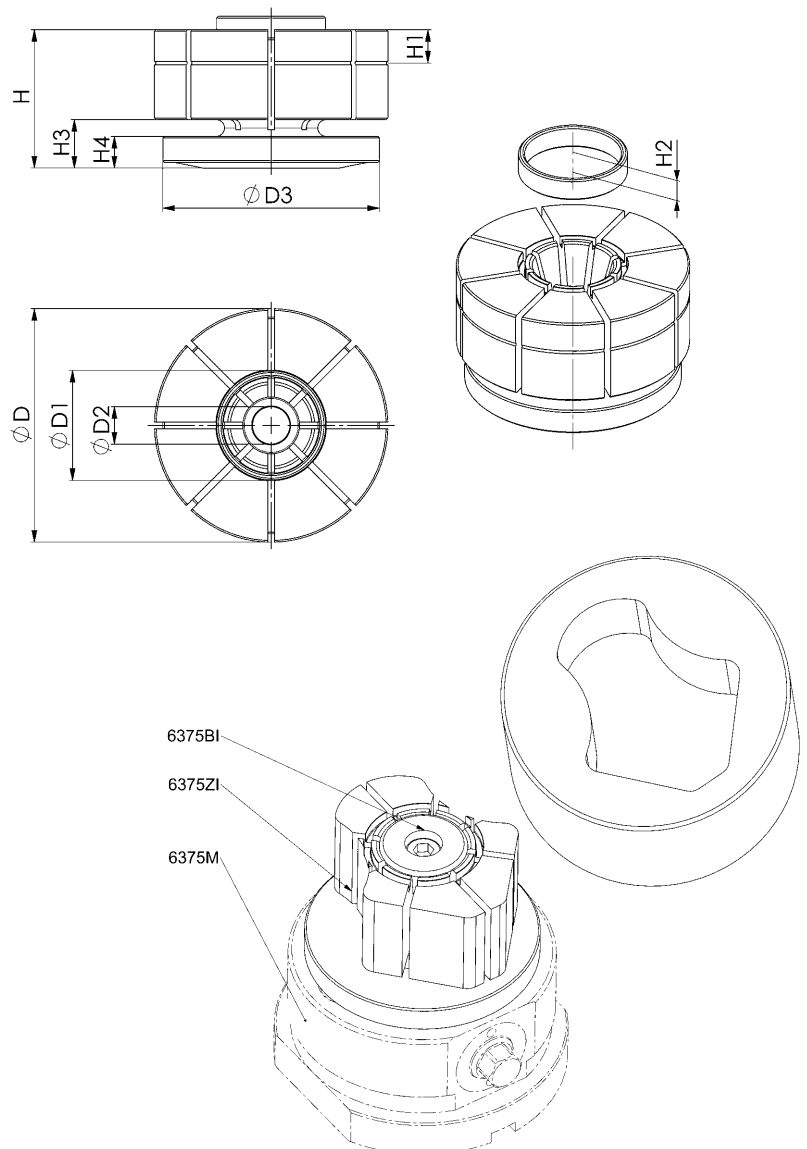
The collet attachment is fastened using fastening kit 6375BI (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the circlip. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 10 mm. Then the circlip is removed, and the workpiece can be clamped. To secure new workpiece contours, the collet attachment can be milled off up to a diameter (D1).

Advantage:

- Clamping of blind holes and through-holes
- Free-form clamping
- Clamping of delicate and thin-walled workpieces
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

Note:

The collet attachment must always be clamped with the workpiece or circlip. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



Subject to technical alterations.

No. 6375ZA

Collet attachment outside clamping

Collet attachment made of high-strength aluminium, hard anodised or polyamide.

With locking bolt made of tempered steel, burnished.

| Order no. | Size | dia. D | dia. D1 | dia. D2 | H | H1 | H2 | Material | Clamping stroke Ø [mm] | Weight [g] |
|-----------|------|--------|---------|---------|----|----|----|------------|---------------------------|---------------|
| 567123 | 10 | 70 | 61 | 17,7 | 30 | 15 | 6 | EN AW 7075 | 0,3 | 274 |
| 567124 | 20 | 99 | 90 | 22,7 | 50 | 25 | 10 | EN AW 7075 | 0,3 | 935 |
| 550278 | 20 | 99 | 90 | 22,7 | 50 | 25 | 10 | Polyamid | 1,0 | 360 |

Design:

Collet attachments are always supplied with locking bolt.

Application:

The collet attachment is fastened using fastening kit 6375BA (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the locking bolt. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Then the locking bolt is removed, and the workpiece can be clamped.

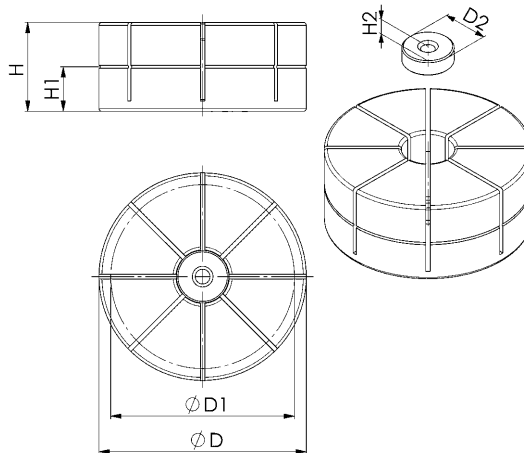
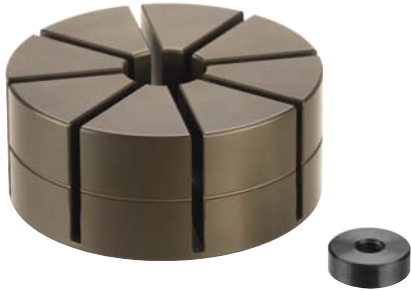
The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced. The maximum workpiece diameter is specified in the table with D1.

Advantage:

- Clamping of delicate and thin-walled workpieces
- Free-form clamping
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

Note:

The collet attachment must always be clamped with the workpiece or locking bolt. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



No. 6375ZA

Collet attachment outside clamping

Collet attachment made of high-strength aluminium, hard anodised.

With locking bolt made of tempered steel, burnished.



| Order no. | Size | dia. D | dia. D1 | dia. D2 | H | H1 | H2 | H3 | Material | Clamping stroke Ø [mm] | Weight [g] |
|-----------|------|--------|---------|---------|----|----|----|----|------------|------------------------|------------|
| 428656 | 20 | 149 | 140 | 23 | 50 | 25 | 10 | 10 | EN AW 7075 | 0,3 | 880 |

Design:

Collet attachments are always supplied with locking bolt.

Application:

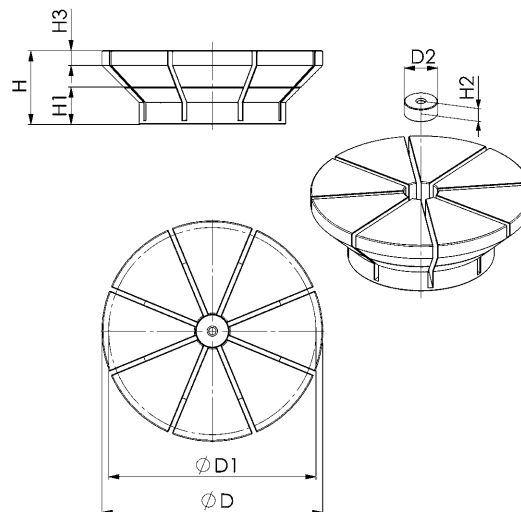
The collet attachment is fastened using fastening kit 6375BA (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the locking bolt. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Then the locking bolt is removed, and the workpiece can be clamped. The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced. The maximum workpiece diameter is specified in the table with D1.

Advantage:

- Clamping of delicate and thin-walled workpieces
- Free-form clamping
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

Note:

The collet attachment must always be clamped with the workpiece or locking bolt. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



No. 6375H

Hydraulic collet incl. body

Operating pressure for opening: min. 40 bar - max. 60 bar.



| Order no. | Clamping force max.* | Clamping stroke \varnothing | Weight |
|-----------|----------------------|-------------------------------|--------|
| | [kN] | [mm] | [Kg] |
| 545582 | 13 | 0,3 | 5,6 |

Design:

Hydraulic pressure of 40 - 60 bar is required for opening the collet. In the de-pressurised state, the collet attachment is securely tensioned by the integrated spring package. The main body is made of burnished steel. The collet attachment, which is supplied as standard, has a diameter of 99 mm and is made of anodised, high-strength aluminium. The hydraulic clamping unit is protected against dirt and cooling water. Circumferential clamping edge for fastening to the machine table. The holder for the AMF K20 Zero Point system, as well as grooves for positioning on AMF Zero Point clamping modules with indexing, are applied to the underside. For automated operation, a hydraulic connection, sealed in the delivered condition, is present on the underside. The lateral hydraulic connection is suitable for the mounting of a quick-release coupling with connection thread G1/4.

Application:

For clamping complex workpiece contours for 5-sided machining in the machine tool. The counterplate of the workpiece is milled into the collet attachment with a minimum clamping depth of 2 mm. Since the clamping force is evenly applied to the component in a radial direction, the counterplate is clamped warp-free. Thanks to the simple collet attachment replacement, various workpieces can be quickly and securely clamped for 5-sided machining. The collet attachment can be milled off up to a height of H1, thus allowing new workpiece contours to be introduced.

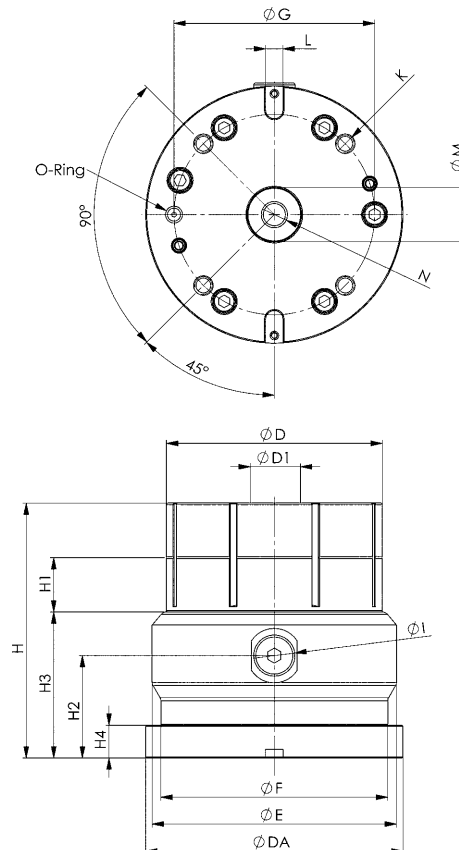
Note:

With a mounted collet attachment, the clamping unit must not be closed without a workpiece.

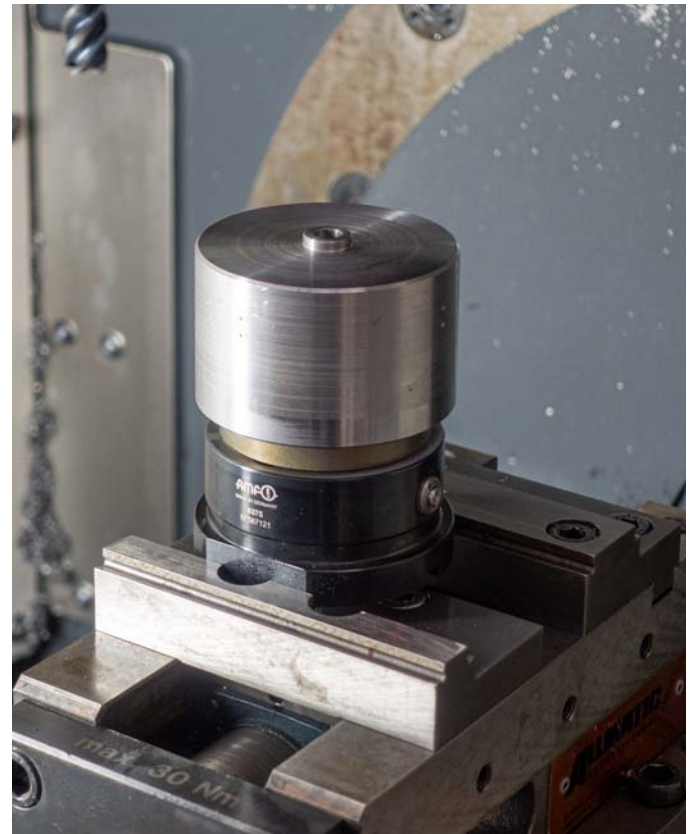
* The max. clamping force of 13 kN is exerted axially to the collet and does not refer to the clamping force exerted on the component. This varies according to the machining height.

Dimensions:

| Order no. | dia. D | dia. D1 | dia. DA | dia. E | dia. F | dia. G | H | H1 | H2 | H3 | H4 | dia. I | K | L | dia. M | N |
|-----------|--------|---------|---------|--------|--------|--------|-----|----|----|----|----|--------|----|------|--------|-----|
| 545582 | 99 | 23 | 118 | 112 | 104 | 92 | 117 | 25 | 47 | 67 | 15 | G1/4 | M8 | 8 K7 | 25 | M12 |



Subject to technical alterations.



No. 6375BI

Fastening kit for collet attachment inside clamping

With tension bolt made of tempered steel, plasma-nitrided and burnished and cylinder screw ISO4762, strength class 12.9.

NEW!



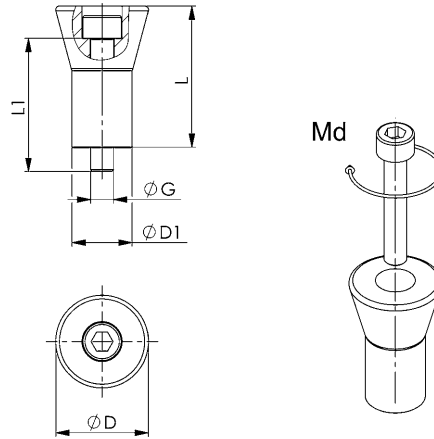
| Order no. | Size | dia. D [mm] | dia. D1 [mm] | G [mm] | Md [Nm] | L [mm] | L1 [mm] | Weight [g] |
|-----------|------|----------------|-----------------|-----------|------------|-----------|------------|---------------|
| 567129 | 10 | 25 | 16 | M6 | 14 | 37 | 35 | 73 |
| 567130 | 20 | 25 | 19 | M8 | 25 | 42 | 40 | 93 |

Application:

For fastening the collet attachments to the inside clamping of workpieces.

Note:

The fastening kit must be tightened with the specified torque.



No. 6375BA

Fastening kit for collet attachment outside clamping

With disc made of tempered steel and flat-head screw ISO10642.

NEW!



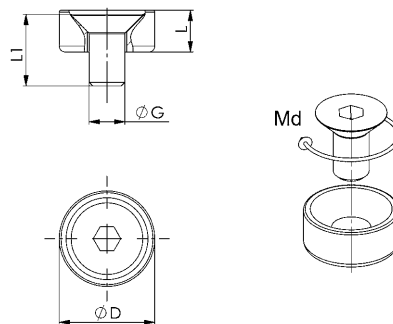
| Order no. | Size | dia. D [mm] | G [mm] | Md [Nm] | L [mm] | L1 [mm] | Weight [g] |
|-----------|------|----------------|-----------|------------|-----------|------------|---------------|
| 567127 | 10 | 16 | M6 | 8 | 7 | 12 | 11 |
| 567128 | 20 | 21 | M8 | 10 | 7 | 16 | 20 |

Application:

For fastening the collet attachments to the outside clamping of workpieces.

Note:

The fastening kit must be tightened with the specified torque.

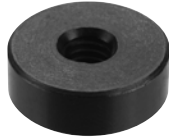


Nr. 6375SBA

Safety bolt for collet attachment - outside clamping

Tempered steel, burnished.

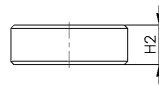
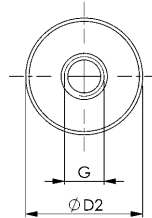
NEW!



| Order no. | Size | dia. D2 [mm] | G [mm] | H2 [mm] | Weight [g] |
|-----------|------|-----------------|-----------|------------|---------------|
| 568511 | 10 | 17,7 | M6 | 6 | 10,4 |
| 568512 | 20 | 22,7 | M6 | 10 | 30 |

Application:

To attach the workpiece contour, the collet attachment for outside clamping must be clamped with the safety bolt.



Nr. 6375SRI

Circlip for collet attachment - inside clamping

Tempered steel, burnished.

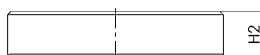
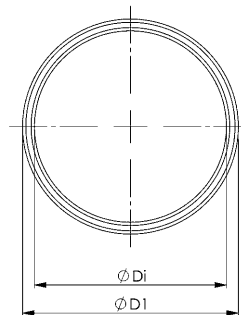
NEW!



| Order no. | Size | dia. D1 [mm] | ØDi [mm] | H2 [mm] | Weight [g] |
|-----------|------|-----------------|-------------|------------|---------------|
| 568513 | 10 | 32,7 | 29,1 | 7 | 9,2 |
| 568514 | 20 | 44,7 | 35,2 | 10 | 44,5 |

Application:

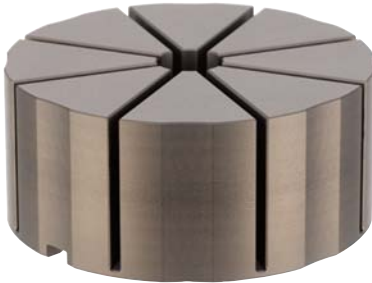
To attach the workpiece contour, the collet attachment for inside clamping must be clamped with the circlip.



No. 6370ZSZ-112

Collet attachment for clamping module KH20 and BH20, hydr.

Material: high-strength aluminium.



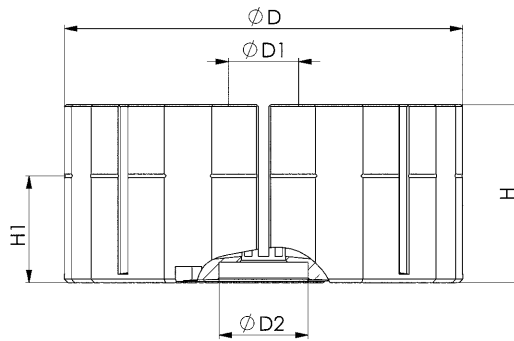
| Order no. | dia. D | dia. D1 | ØD2 0/+0.01 | Clamping stroke Ø [mm] | H | H1 | Weight [g] |
|-----------|--------|---------|----------------|---------------------------|----|----|---------------|
| 550286 | 112 | 20 | 25 | 0,5 | 50 | 30 | 1133 |

Design:

The collet attachment with a diameter of 112 mm is suitable for the AMF zero-point hydraulic clamping modules KH20 (Order no. 428425) and BH20 (Order no. 534412) with indexing. The collet is made from anodised, high-strength aluminium.

Application:

The collet attachment is placed on the AMF Zero Point clamping system size KH20 or BH20 in the hydraulic version and guides the radial clamping force to the workpiece after the clamping module is closed. The workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced. The maximum workpiece diameter is 100 mm.



No. 6370ZSB

Mounting kit for collet attachment

for collet No. 6370ZSZ-112

| Order no. | Size | Weight [g] |
|-----------|------|---------------|
| 550287 | 20 | 190 |

Design:

- The mounting set includes:
- 1 pull-stud size 20, design: sword
 - 1 captive screw size 20
 - 1 lock nut M12
 - 2 indexing notches, width 8 mm

Application:

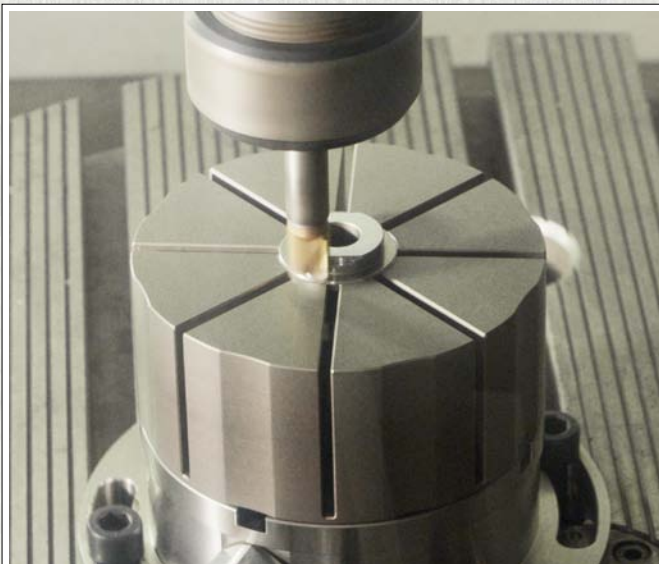
The mounting set is mounted with the collet attachment 112 mm, order no. 550286. After installation, the collet attachment can be securely and hydraulically clamped onto the AMF clamping modules, size 20.



**Collet attachment for clamping
module KH20 and BH20, hydr.**
6370ZSZ-112

**Mounting kit for collet
attachment**
6370ZSB

**Assembly element K20,
hydraulic, with indexing**
6210IH



Subject to technical alterations.

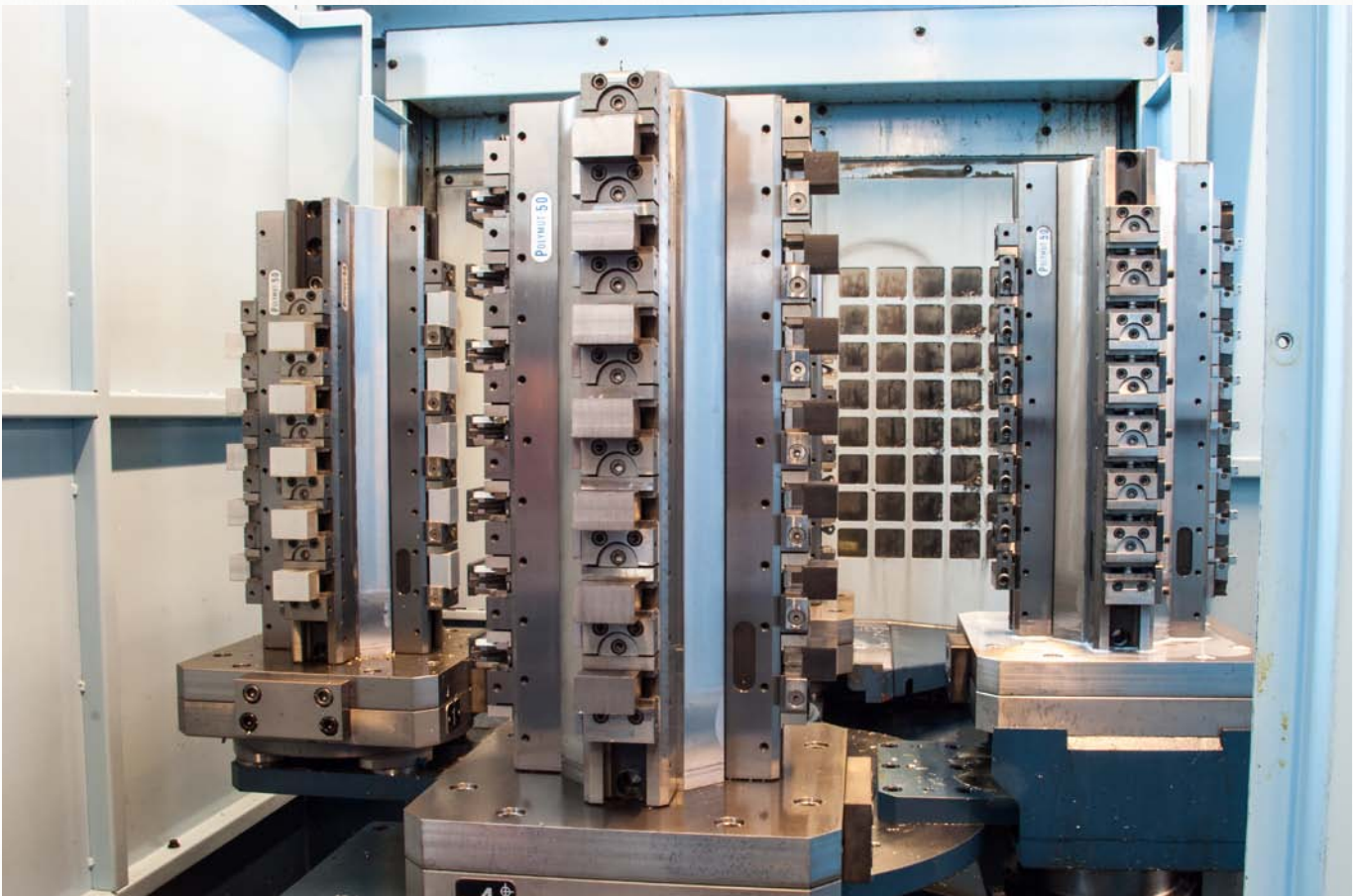


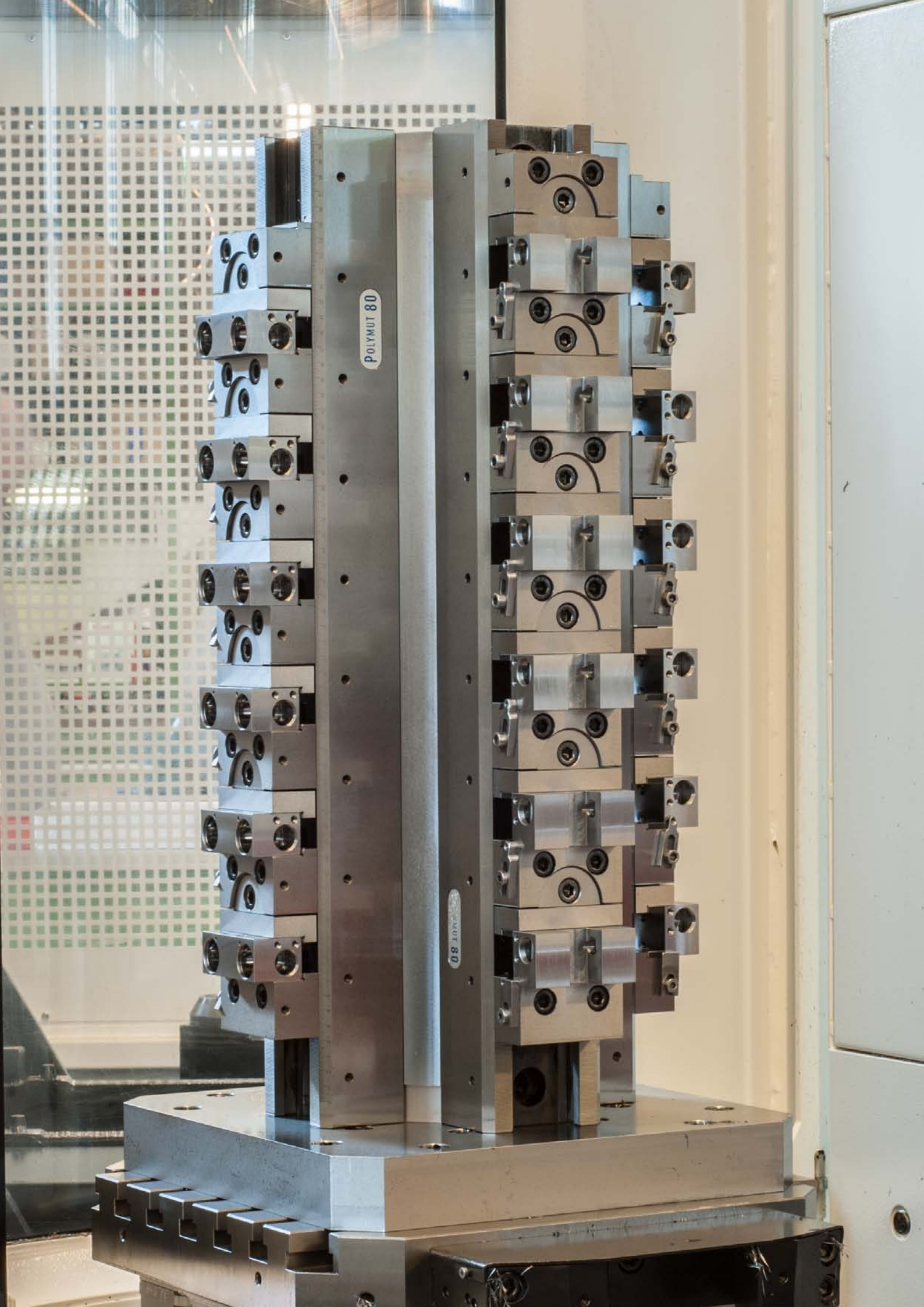
Subject to technical alterations.



- + Outstanding price-performance ratio
- + Drastically reduced tooling time
- + Immediate improvement of productivity
- + Repeat accuracy < 5um
- + Stainless steel
- + Form fit







POLYMUT 80

POLYMUT 80

Nr. 6378

Multiple clamping system „EasyVise“

Basic set for 2-way or 4-way clamping in a practical case. System made of high-strength aluminium, black anodised. Clamping jaws and supports made of hardened steel.

NEW!



| Order no. | B Jaw width [mm] | Fsp [kN] | G [mm] | G1 [mm] | SW [mm] | Md [Nm] | Weight [g] |
|-----------|------------------|----------|--------|---------|---------|---------|------------|
| 568438 | 28 | 10 | M12 | M5 | 19 | 40 | 2505 |
| 568439 | 48 | 10 | M12 | M5 | 19 | 40 | 3027 |

Application:

The patented, versatile multiple clamping system is designed for use on four- and five-axis milling machines. Moreover, the system can be adapted to the AMF zero-point clamping system size 10 or size 20 using an adapter (order no. 568440). In addition, it is compatible for all manufacturers of clamping equipment with pitch spacing of 52 mm, thread size M8. It can clamp 2 to 4 workpieces at the same time. The double clamping on a clamping plane eliminates distortions in the clamping system. After determination of the clamping width (workpiece height), the system is built up using suitable spacer sleeves. **Details can be found in the accompanying installation manual.**

Features:

- Clamping and machining of 2 or 4 workpieces simultaneously.
- Clamping of several workpieces through actuation of a clamping stud and automatic clamping sequence.

Advantage:

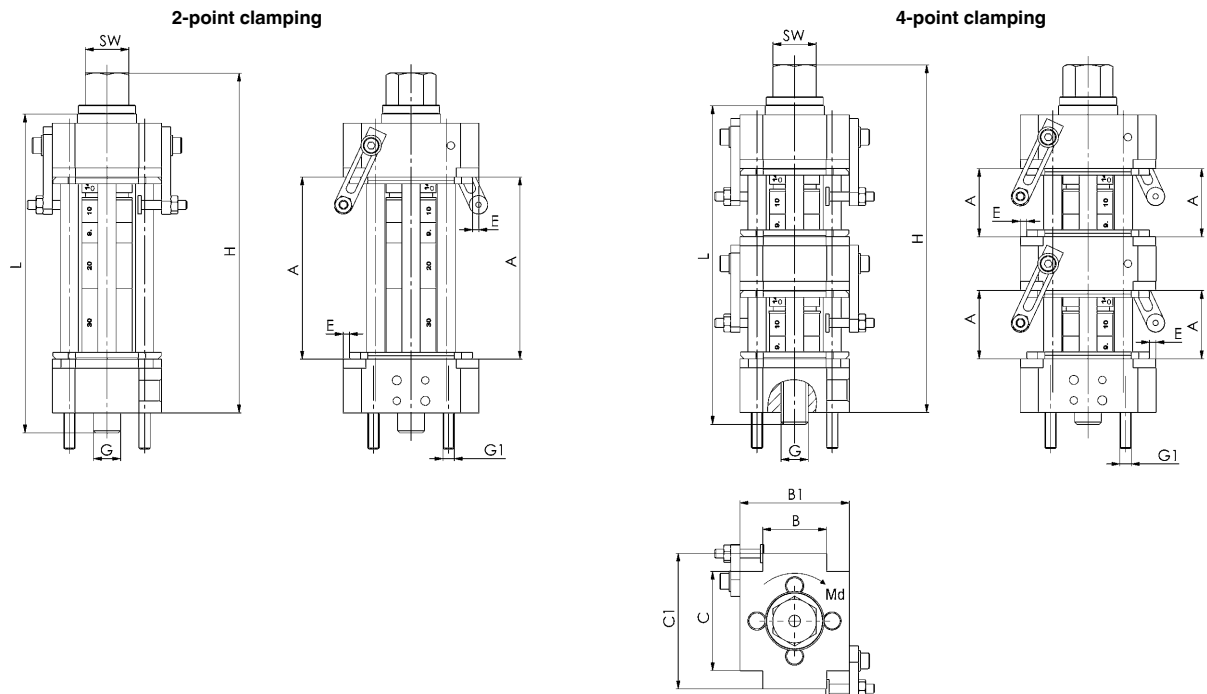
- Set-up time savings possible through placement of several components at the same time.
- Optimised parallel placement of parts through automatic clamping sequence.
- No distortions in the clamping system from double clamping for each clamping level.
- Low interfering contour of the clamping equipment.
- Modular structure.
- Compatible for all manufacturers of clamping equipment with pitch spacing of 52 mm, thread size M8.
- The low installation size of the clamping system guarantees optimal accessibility.

Note:

- The workpieces must not be clamped on one side, but always only parallel, and clamping must cover at least 3/4 of the clamping jaw width.
- Tightening torque specifications must be maintained.
- Adapter (order no. 568440) available as an option.

On request:

- Additional jaw widths 58 and 80 mm.
- 6-point clamping.

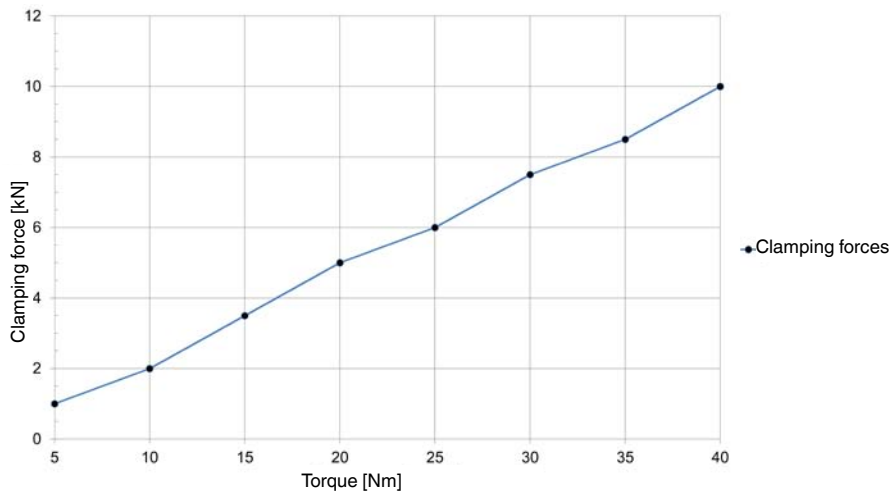


Dimensions:

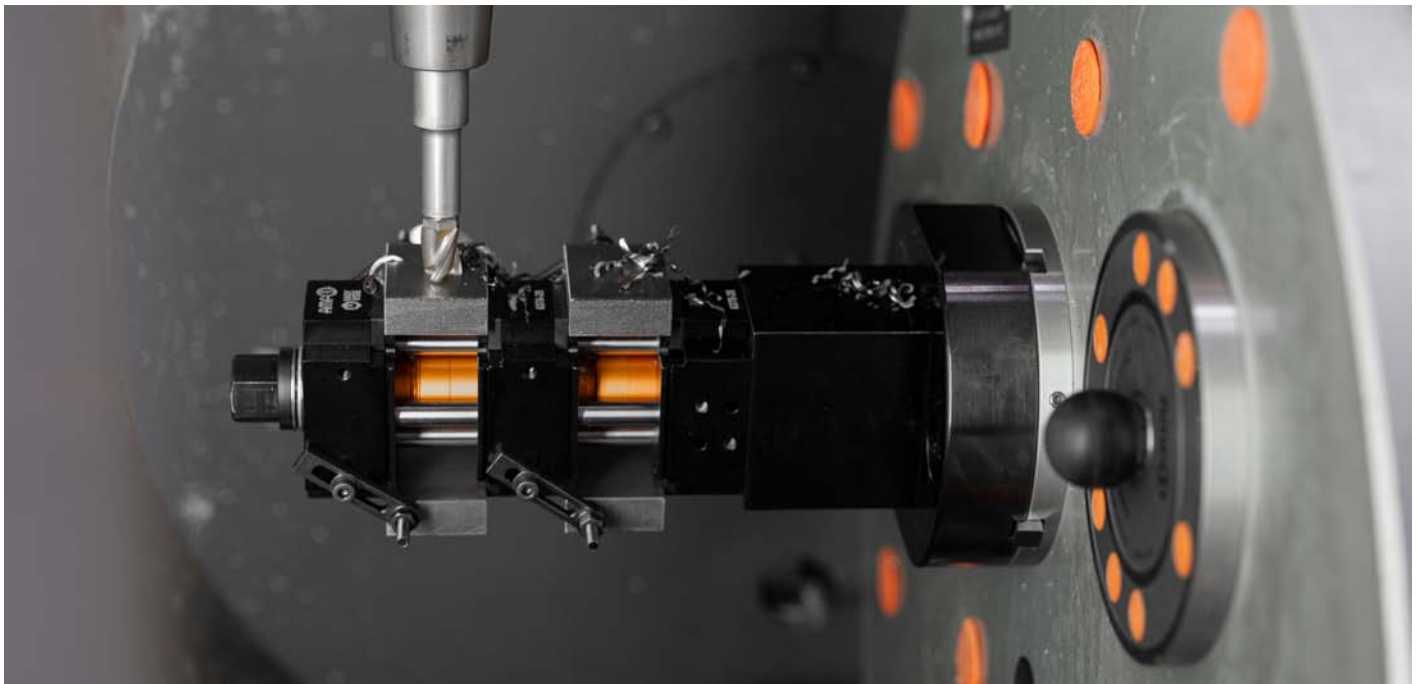
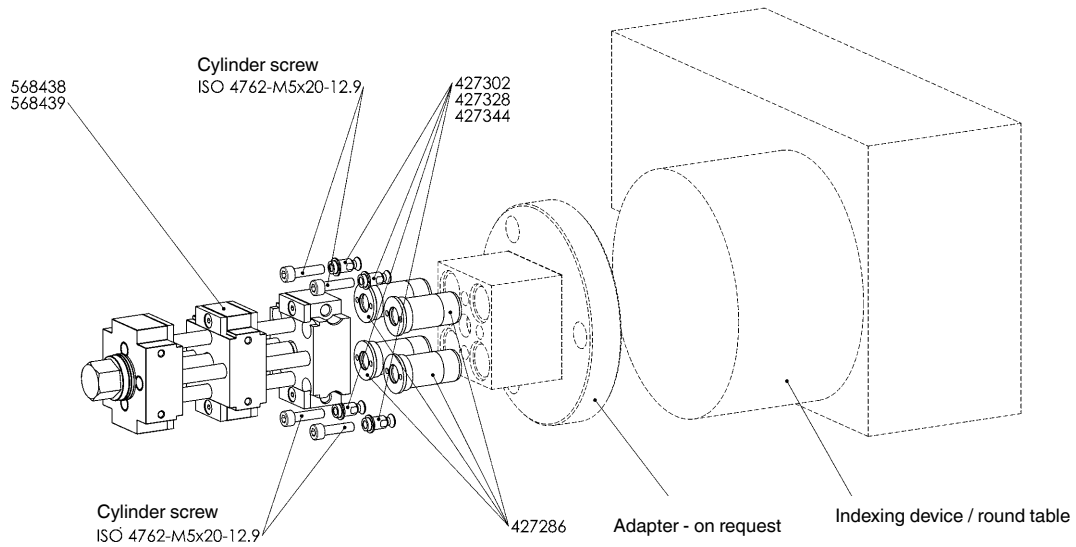
| Order no. | A 2-point clamping width [mm] | A 4-point clamping width [mm] | B1 [mm] | C [mm] | C1 [mm] | E [mm] | H 2-point clamping [mm] | H 4-point clamping [mm] |
|-----------|-------------------------------|-------------------------------|---------|--------|---------|--------|-------------------------|-------------------------|
| 568438 | 9 - 82 | 9 - 32 | 48 | 44 | 60 | 2,8 | 82,2 - 151,2 | 118,8 - 156,8 |
| 568439 | 9 - 82 | 9 - 32 | 48 | 60 | 60 | 2,8 | 82,2 - 151,2 | 118,8 - 156,8 |

Subject to technical alterations.

Clamping force - Clamping station EasyVise:



Application example:



Subject to technical alterations.



Adapter for multiple clamping system „EasyVise“

Nr. 6378A

Adapter for multiple clamping system „EasyVise“

Tempered steel, black oxide finish.

With 2 cylinder screws ISO4762 M12 and cover caps.

NEW!



| Order no. | Size | A [mm] | B [mm] | H [mm] | Weight [g] |
|-----------|-------|-----------|-----------|-----------|---------------|
| 568440 | 28/48 | 48 | 60 | 80 | 3080 |

Application:

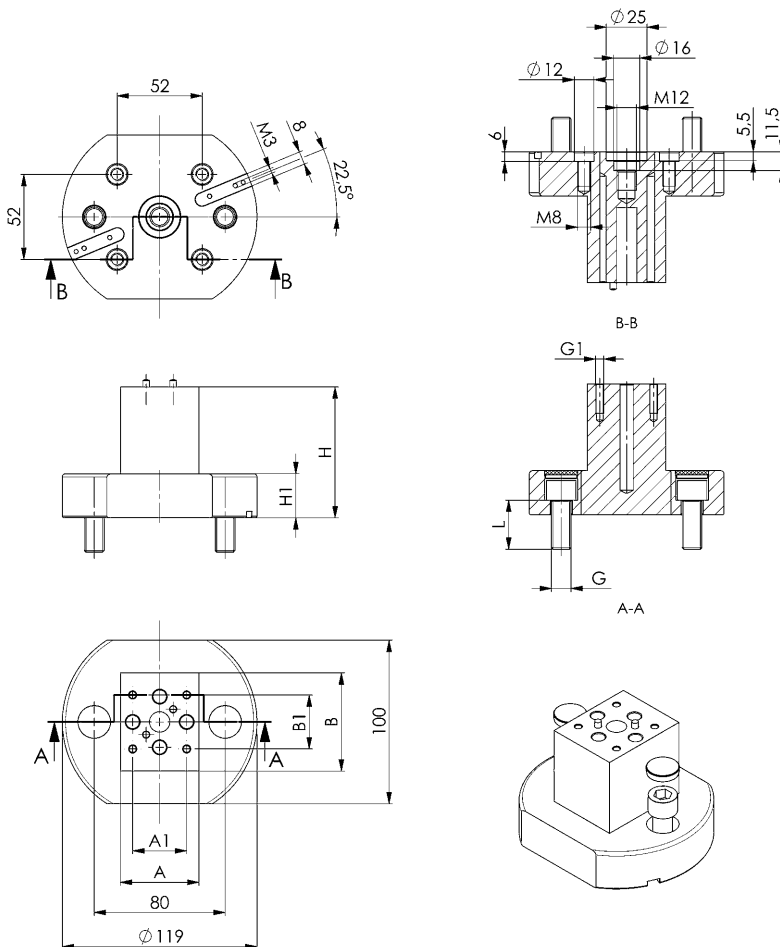
The adapter serves as receptacle for the multiple clamping system EASY VISE. It can be fastened to the machine table using a machine vice, T-slots or the AMF zero-point clamping system size 10 or size 20.

Advantage:

- Compatible for all manufacturers of clamping equipment with pitch spacing of 52 mm, thread size M8.

Note:

- Pay attention to the correct screw length when using the system on T-slot tables with a slot larger than 14.

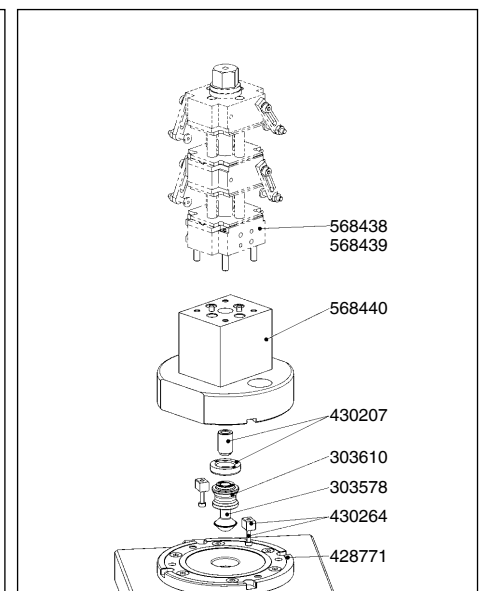
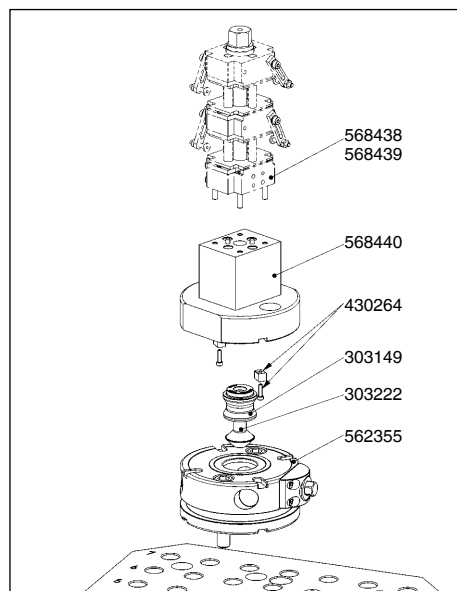
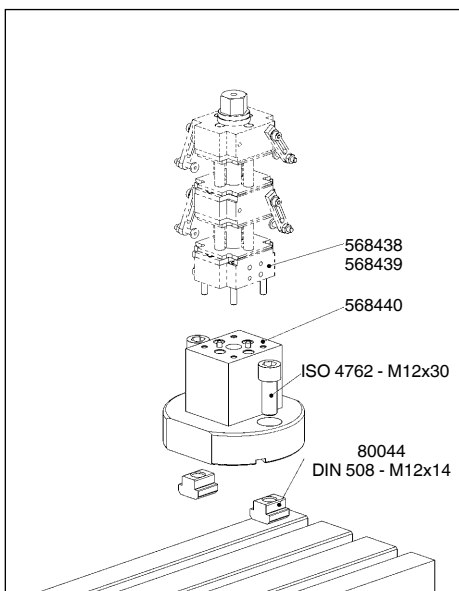
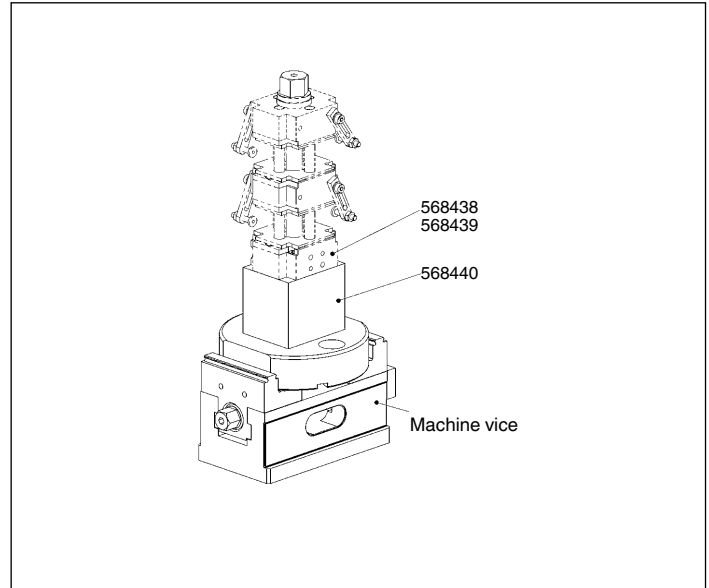
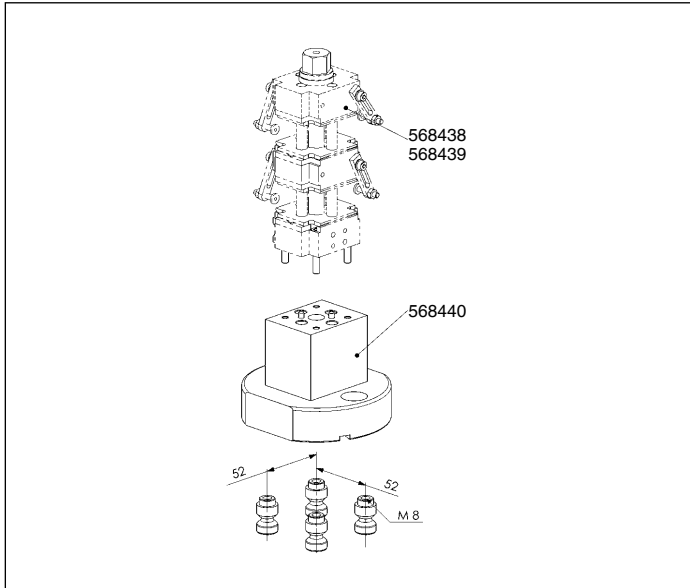


Dimensions:

| Order no. | Size | A1 [mm] | B1 [mm] | G [mm] | G1 [mm] | H1 [mm] | L [mm] |
|-----------|-------|------------|------------|-----------|------------|------------|-----------|
| 568440 | 28/48 | 33 | 33 | M12 | M5 | 27 | 30 |

Subject to technical alterations.

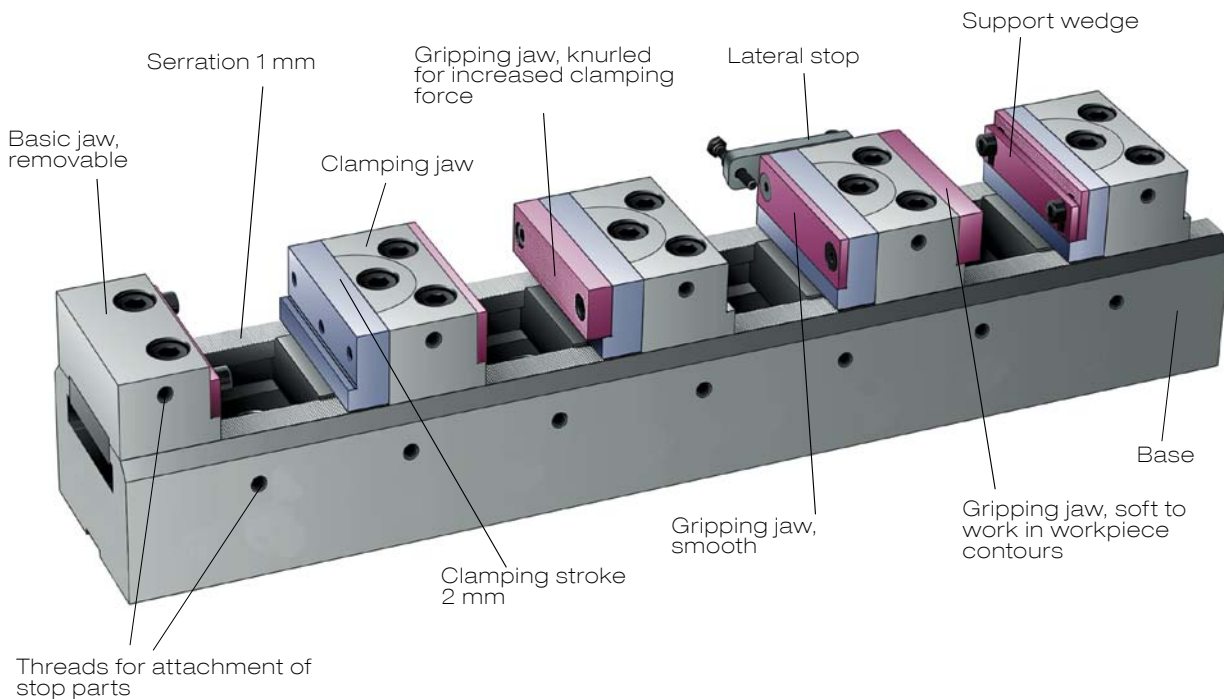
Application examples:



Subject to technical alterations.

MULTIPLE CLAMPING SYSTEM NO. 6371 - THE ADVANTAGES AT A GLANCE

- > Precision multiple clamping fixture
- > Insert steel hardened 60 HRC
- > Up to 16 clamping points, depending on the tool size
- > Simple and precise setting of the clamping jaws due to serrated contact surfaces
- > Positioning step 1 mm
- > Scaling on the basic module and reference mark on the jaws permit positioning without measurement and inspection equipment
- > Positive-locking connection of the clamping jaws
- > Clamping per clamping point with only one screw
- > Jaw width 50 and 80
- > Modular design: equipment for one or more workpieces as desired
- > Workpiece contact surfaces integrated into jaws
- > Usable on machine tables, fixture and quick change systems



WORK-PIECE QUANTITIES FOR MULTIPLE CLAMPING SYSTEMS

| Size | Length [mm] | Workpiece quantity | | | | | | | | | | | | | | | |
|------|-------------|-------------------------------|-----|-----|-----|-----|----|----|----|----|----|----|----|----|----|----|----|
| | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 |
| | | Max. workpiece dimension [mm] | | | | | | | | | | | | | | | |
| 50 | 250 | 191 | 78 | 41 | 22 | 11 | | | | | | | | | | | |
| | 320 | 261 | 113 | 64 | 39 | 25 | 15 | 8 | | | | | | | | | |
| | 500 | 441 | 203 | 124 | 84 | 61 | 45 | 34 | 25 | 18 | 13 | 9 | | | | | |
| | 600 | 541 | 253 | 157 | 109 | 81 | 61 | 48 | 38 | 30 | 23 | 18 | 14 | 10 | | | |
| | 650 | 591 | 278 | 174 | 122 | 91 | 70 | 56 | 44 | 35 | 28 | 22 | 18 | 14 | 10 | | |
| | 700 | 641 | 303 | 191 | 134 | 101 | 78 | 62 | 50 | 41 | 33 | 27 | 22 | 18 | 14 | 11 | 8 |
| 80 | 350 | 261 | 105 | 52 | 26 | 11 | | | | | | | | | | | |
| | 500 | 411 | 180 | 102 | 64 | 41 | 25 | 14 | | | | | | | | | |
| | 600 | 511 | 230 | 136 | 89 | 61 | 42 | 28 | 18 | 11 | | | | | | | |
| | 650 | 561 | 255 | 152 | 101 | 71 | 50 | 36 | 25 | 16 | | | | | | | |
| | 700 | 611 | 280 | 169 | 114 | 81 | 59 | 43 | 31 | 22 | 14 | | | | | | |

SIMPLE MOUNTING IN TWO STEPS

1 FASTENING THE JAWS ON THE BASIC ELEMENT (MOUNTING BOLTS)

Tightening torque for mounting bolts of strength class 12.9:

| Clamping jaw width | Attachment of basic jaws | Attachment of clamping jaws |
|--------------------|----------------------------|-----------------------------|
| 50 | 2 x M6, max. 25 Nm | 2 x M6, max. 20 Nm |
| 80 | 2 x M10, max. 30 Nm | 2 x M10, max. 30 Nm |

2 CLAMPING THE WORKPIECE BY TIGHTENING THE CLAMPING JAWS

FIRST STEP:

Lightly tighten the clamping bolt. As a result, the workpiece is correctly positioned. Always start at the last clamping jaw.

SECOND STEP:

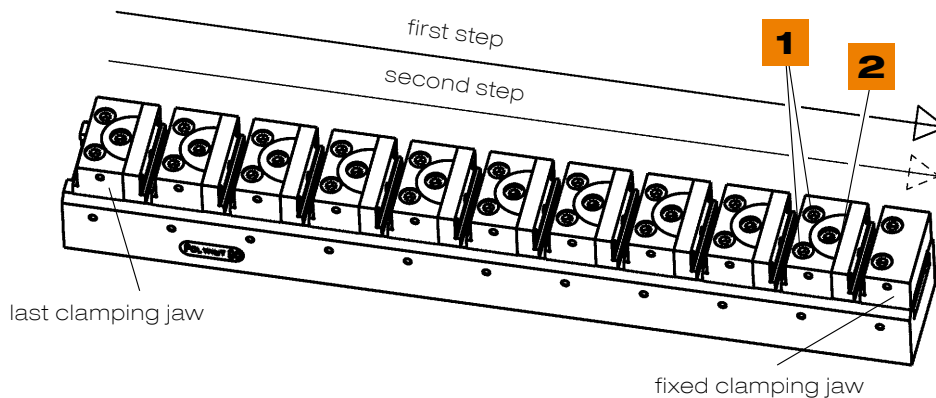
Then tighten the clamping bolt with a torque wrench (pay attention to the diagrams shown below). Also always start at the last clamping jaw.

NOTE:

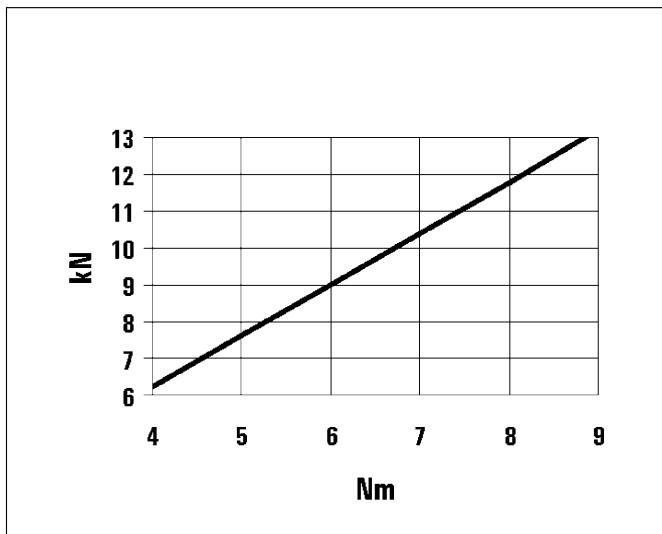
Recommended lubricant for the clamping screws of the jaws and the cone: **Molykote TP42**

You can obtain a centring sleeve for marking and positioning under the following order numbers:

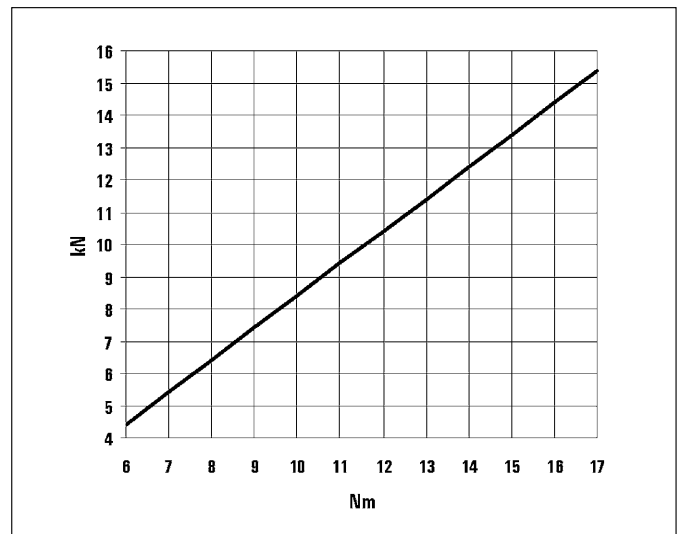
1. For fitting diameter 16F7 with thread M12 = Order No. 78006
2. For fitting diameter 22F7 with thread M16 = Order No. 78238



Clamping jaw width 50 – **max. clamping force 12 kN**



Clamping jaw width 80 – **max. clamping force 15 kN**



No. 6371G-50

Base element

Jaw width 50 mm.

Bore spacing 40 mm. Hardened 60 HRC, 1 mm splines. Fits all AMF pitch systems: 40 mm pitch, M12, ø16 F7.

| Order no. | Size | Length [mm] | Clamping force [kN] | Weight [Kg] |
|-----------|------------|----------------|------------------------|----------------|
| 304873 | 50-250-040 | 250 | 12 | 3,3 |
| 304923 | 50-320-040 | 320 | 12 | 4,2 |
| 304899 | 50-500-040 | 500 | 12 | 6,6 |
| 304949 | 50-600-040 | 600 | 12 | 8,0 |
| 304915 | 50-650-040 | 650 | 12 | 8,7 |
| 304964 | 50-700-040 | 700 | 12 | 9,3 |

No. 6371G-80

Base element

Jaw width 80 mm.

Bore spacing 40 mm. Hardened 60 HRC, 1 mm splines. Fits all AMF pitch systems: 40 mm pitch, M12, ø16 F7.

| Order no. | Size | Length [mm] | Clamping force [kN] | Weight [Kg] |
|-----------|------------|----------------|------------------------|----------------|
| 304774 | 80-350-040 | 350 | 15 | 11,1 |
| 304824 | 80-500-040 | 500 | 15 | 15,8 |
| 304790 | 80-600-040 | 600 | 15 | 18,9 |
| 304840 | 80-650-040 | 650 | 15 | 20,6 |
| 304816 | 80-700-040 | 700 | 15 | 22,1 |

No. 6371G-80

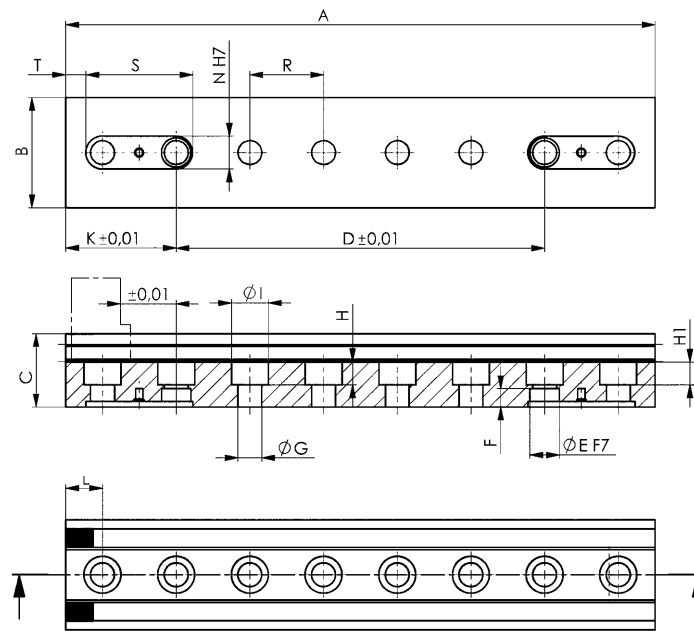
Base element

Jaw width 80 mm.

Bore spacing 50 mm. Hardened 60 HRC, 1 mm splines. Fits all AMF pitch systems: 50 mm pitch, M16, ø22 F7.

| Order no. | Size | Length [mm] | Clamping force [kN] | Weight [Kg] |
|-----------|------------|----------------|------------------------|----------------|
| 304766 | 80-350-050 | 350 | 15 | 10,7 |
| 304782 | 80-500-050 | 500 | 15 | 15,5 |
| 304733 | 80-600-050 | 600 | 15 | 18,6 |
| 304758 | 80-650-050 | 650 | 15 | 20,0 |
| 304808 | 80-700-050 | 700 | 15 | 21,7 |





Dimensions:

| Order no. | Size | A | B | C | D | dia. E F7 | F | dia. G | H | H1 | dia. I | K | L | NH7 | R | S | T |
|-----------|------------|-----|----|----|-----|-----------|----|--------|------|------|--------|-----|----|-----|----|----|-----|
| 304873 | 50-250-040 | 250 | 60 | 40 | 120 | 16 | 10 | 13 | 12,5 | 12,5 | 19 | 65 | 25 | 18 | 40 | 58 | 16 |
| 304923 | 50-320-040 | 320 | 60 | 40 | 200 | 16 | 10 | 13 | 12,5 | 12,5 | 19 | 60 | 20 | 18 | 40 | 58 | 11 |
| 304899 | 50-500-040 | 500 | 60 | 40 | 360 | 16 | 10 | 13 | 12,5 | 12,5 | 19 | 70 | 30 | 18 | 40 | 58 | 21 |
| 304949 | 50-600-040 | 600 | 60 | 40 | 400 | 16 | 10 | 13 | 12,5 | 12,5 | 19 | 100 | 20 | 18 | 40 | 58 | 51 |
| 304915 | 50-650-040 | 650 | 60 | 40 | 400 | 16 | 10 | 13 | 12,5 | 12,5 | 19 | 125 | 45 | 18 | 40 | 58 | 51 |
| 304964 | 50-700-040 | 700 | 60 | 40 | 400 | 16 | 10 | 13 | 12,5 | 12,5 | 19 | 150 | 30 | 18 | 40 | 58 | 101 |

| Order no. | Size | A | B | C | D | dia. E F7 | F | dia. G | H | H1 | dia. I | K | L | NH7 | R | S | T |
|-----------|------------|-----|----|----|-----|-----------|----|--------|------|------|--------|-----|----|-----|----|----|-----|
| 304774 | 80-350-040 | 350 | 90 | 60 | 200 | 16 | 13 | 13 | 12,5 | 12,5 | 19 | 75 | 35 | 18 | 40 | 58 | 26 |
| 304824 | 80-500-040 | 500 | 90 | 60 | 360 | 16 | 13 | 13 | 12,5 | 12,5 | 19 | 70 | 30 | 18 | 40 | 58 | 21 |
| 304790 | 80-600-040 | 600 | 90 | 60 | 400 | 16 | 13 | 13 | 12,5 | 12,5 | 19 | 100 | 20 | 18 | 40 | 58 | 51 |
| 304840 | 80-650-040 | 650 | 90 | 60 | 400 | 16 | 13 | 13 | 12,5 | 12,5 | 19 | 125 | 45 | 18 | 40 | 58 | 76 |
| 304816 | 80-700-040 | 700 | 90 | 60 | 400 | 16 | 13 | 13 | 12,5 | 12,5 | 19 | 150 | 30 | 18 | 40 | 58 | 101 |

| Order no. | Size | A | B | C | D | dia. E F7 | F | dia. G | H | H1 | dia. I | K | L | NH7 | R | S | T |
|-----------|------------|-----|----|----|-----|-----------|----|--------|----|----|--------|-----|----|-----|----|----|----|
| 304766 | 80-350-050 | 350 | 90 | 60 | 200 | 22 | 13 | 17 | 17 | 17 | 25 | 75 | 25 | 18 | 50 | 68 | 16 |
| 304782 | 80-500-050 | 500 | 90 | 60 | 350 | 22 | 13 | 17 | 17 | 17 | 25 | 75 | 25 | 18 | 50 | 68 | 16 |
| 304733 | 80-600-050 | 600 | 90 | 60 | 400 | 22 | 13 | 17 | 17 | 17 | 25 | 100 | 50 | 18 | 50 | 68 | 41 |
| 304758 | 80-650-050 | 650 | 90 | 60 | 400 | 22 | 13 | 17 | 17 | 17 | 25 | 125 | 25 | 18 | 50 | 68 | 66 |
| 304808 | 80-700-050 | 700 | 90 | 60 | 400 | 22 | 13 | 17 | 17 | 17 | 25 | 150 | 50 | 18 | 50 | 68 | 91 |

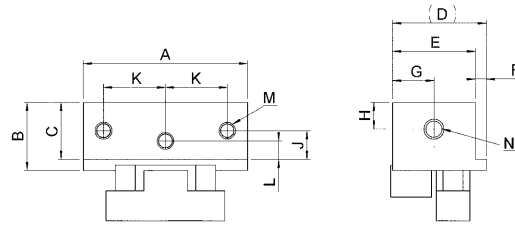
No. 6371

Base jaw, standard

First stop on base element, hardened 60 HRC.



| Order no. | Size | for jaw width | Weight [g] |
|-----------|---------|---------------|------------|
| 265793 | 4101-50 | 50 | 226 |
| 266809 | 4111-80 | 80 | 880 |



Dimensions:

| Order no. | Size | A | B | C | D | E | F | G | H | J | K | L | M | N |
|-----------|---------|----|------|----|----|------|-----|------|---|------|------|-----|------|------|
| 265793 | 4101-50 | 49 | 20,0 | 17 | 28 | 24,7 | 3,3 | 12,4 | 8 | 8,5 | 18,5 | 5,5 | 3xM5 | 2xM6 |
| 266809 | 4111-80 | 78 | 32,2 | 22 | 42 | 38,0 | 4,0 | 19,0 | 8 | 11,0 | 31,5 | 6,0 | 3xM6 | 2xM6 |

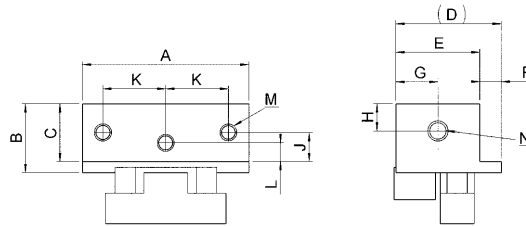
No. 6371

Base jaw, deep

First stop on base element, hardened 60 HRC.



| Order no. | Size | for jaw width | Weight [g] |
|-----------|---------|---------------|------------|
| 290635 | 4121-50 | 50 | 230 |
| 290650 | 4120-80 | 80 | 900 |



Dimensions:

| Order no. | Size | A | B | C | D | E | F | G | H | J | K | L | M | N |
|-----------|---------|----|------|----|----|------|-----|------|----|------|------|-----|------|------|
| 290635 | 4121-50 | 49 | 20,0 | 17 | 31 | 24,7 | 6,3 | 12,4 | 8 | 8,5 | 18,5 | 5,5 | 3xM5 | 2xM6 |
| 290650 | 4120-80 | 78 | 32,2 | 22 | 46 | 38,0 | 8,0 | 19,0 | 10 | 11,0 | 31,5 | 6,0 | 3xM6 | 2xM6 |

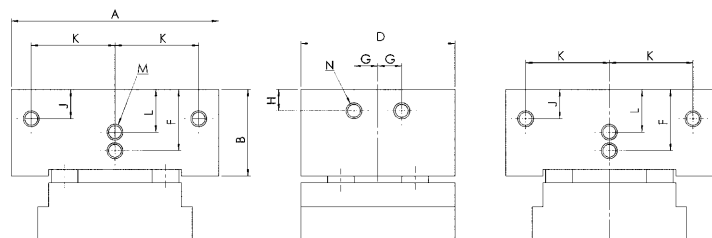
No. 6371

Base jaw, without step

First stop on base element, hardened 60 HRC.



| Order no. | Size | for jaw width | Weight [g] |
|-----------|----------|---------------|------------|
| 304931 | 50105-50 | 50 | 340 |
| 304956 | 80107-80 | 80 | 1330 |



Dimensions:

| Order no. | Size | A | B | D | F | G | H | J | K | L | M | N |
|-----------|----------|----|------|----|----|---|----|------|------|------|------|------|
| 304931 | 50105-50 | 49 | 20,3 | 32 | - | 0 | 8 | 8,5 | 18,5 | 11,5 | 6xM5 | 2xM6 |
| 304956 | 80107-80 | 78 | 32,5 | 50 | 23 | 9 | 10 | 11,0 | 31,5 | 16,0 | 8xM6 | 4xM6 |

Subject to technical alterations.

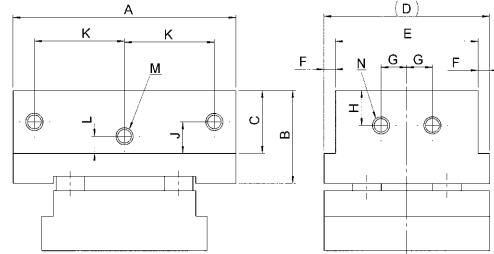
No. 6371

Central jaw

For clamping from two sides, hardened 60 HRC.



| Order no. | Size | for jaw width | Weight [g] |
|-----------|---------|---------------|------------|
| 300905 | 4112-50 | 50 | 370 |
| 300921 | 4300-80 | 80 | 1424 |



Dimensions:

| Order no. | Size | A | B | C | D | E | F | G | H | J | K | L | M | N |
|-----------|---------|----|------|----|----|------|-----|-----|---|------|------|-----|------|------|
| 300905 | 4112-50 | 49 | 20,0 | 17 | 40 | 33,4 | 3,3 | 4,5 | 8 | 8,5 | 18,5 | 5,5 | 6xM5 | 4xM6 |
| 300921 | 4300-80 | 78 | 32,2 | 22 | 58 | 50,0 | 4,0 | 9,0 | 8 | 11,0 | 31,5 | 6,0 | 6xM6 | 4xM6 |

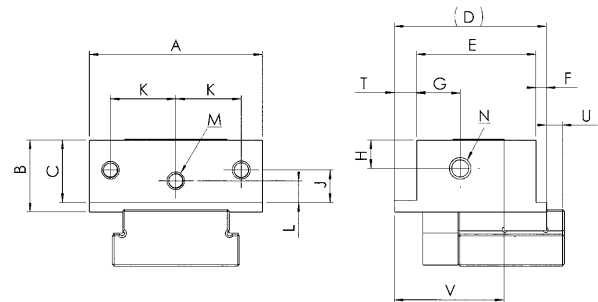
No. 6371

Clamping jaw, standard

With one clamping bolt and two mounting bolts. Hardened 60 HRC.



| Order no. | Size | for jaw width | Clamping force [kN] | Clamping stroke [mm] | Weight [g] |
|-----------|---------|---------------|---------------------|----------------------|------------|
| 265835 | 4102-50 | 50 | 12 | 2 | 373 |
| 266825 | 4110-80 | 80 | 15 | 2 | 1446 |



Dimensions:

| Order no. | Size | A | B | C | D | E | F | G | H | J | K | L | M | N | T | U | V |
|-----------|---------|----|------|----|----|------|---|------|---|------|------|-----|------|------|-----|---|----|
| 265835 | 4102-50 | 49 | 20,0 | 17 | 40 | 33,7 | 3 | 12,4 | 8 | 8,5 | 18,5 | 5,5 | 6xM5 | 2xM6 | 3,3 | 5 | 28 |
| 266825 | 4110-80 | 78 | 32,2 | 22 | 60 | 52,0 | 4 | 19,0 | 8 | 11,0 | 31,5 | 6,0 | 6xM6 | 2xM6 | 4,0 | 7 | 42 |

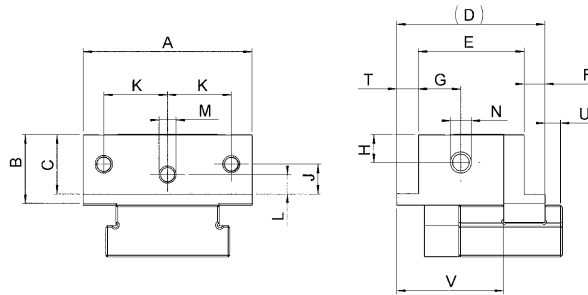
Subject to technical alterations.

No. 6371

Clamping jaw, deep

With one clamping bolt and two mounting bolts.
Hardened 60 HRC.

| Order no. | Size | for jaw width | Clamping force [kN] | Clamping stroke [mm] | Weight [g] |
|-----------|---------|---------------|---------------------|----------------------|------------|
| 300863 | 4109-50 | 50 | 12 | 2 | 390 |
| 300889 | 4119-80 | 80 | 15 | 2 | 1430 |



Dimensions:

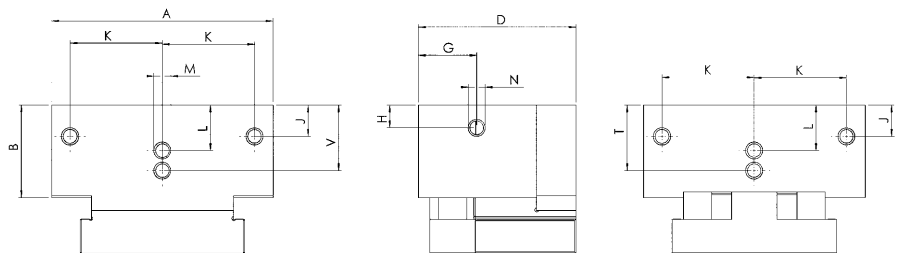
| Order no. | Size | A | B | C | D | E | F | G | H | J | K | L | M | N | T | U | V |
|-----------|---------|----|------|----|----|------|---|------|---|------|------|-----|------|------|-----|---|----|
| 300863 | 4109-50 | 49 | 20,0 | 17 | 43 | 30,7 | 6 | 12,4 | 8 | 8,5 | 18,5 | 5,5 | 6xM5 | 2xM6 | 6,3 | 5 | 31 |
| 300889 | 4119-80 | 78 | 32,2 | 22 | 64 | 48,0 | 8 | 19,0 | 8 | 11,0 | 31,5 | 6,0 | 6xM6 | 2xM6 | 8,0 | 7 | 46 |

No. 6371

Clamping jaw, without step

With one clamping bolt and two mounting bolts.
Hardened 60 HRC.

| Order no. | Size | for jaw width | Clamping force [kN] | Clamping stroke [mm] | Weight [g] |
|-----------|----------|---------------|---------------------|----------------------|------------|
| 304972 | 50101-50 | 50 | 12 | 2 | 370 |
| 304998 | 80101-80 | 80 | 15 | 2 | 1400 |



Dimensions:

| Order no. | Size | A | B | D | G | H | J | K | L | M | N | T | V |
|-----------|----------|----|------|------|------|----|------|------|------|------|------|----|------|
| 304972 | 50101-50 | 49 | 20,0 | 36,5 | 13,2 | 8 | 8,5 | 18,5 | 11,5 | 7xM5 | 2xM6 | - | 17,5 |
| 304998 | 80101-80 | 78 | 32,5 | 55,5 | 20,5 | 10 | 11,0 | 31,5 | 16,0 | 8xM6 | 2xM6 | 23 | 23,0 |

Subject to technical alterations.

No. 6371

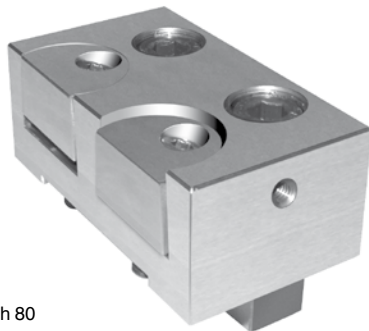
Clamping jaw, with crescent

With one clamping bolt for size 50 or two bolts for size 80, and with two mounting bolts.
Hardened 60 HRC.

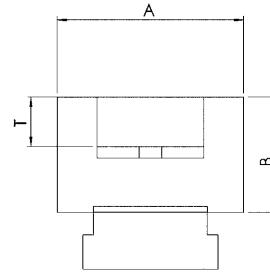
| Order no. | Size | for jaw width | Clamping force [kN] | Clamping stroke [mm] | Weight [g] |
|-----------|----------|---------------|---------------------|----------------------|------------|
| 305011 | 50110-50 | 50 | 12 | 1,4 | 280 |
| 305037 | 80110-80 | 80 | 15 | 1,4 | 1000 |



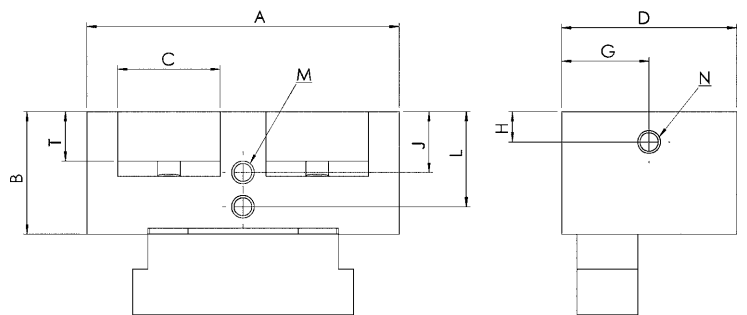
jaw width 50



jaw width 80



jaw width 50



jaw width 80

Dimensions:

| Order no. | Size | A | B | C | D | G | H | J | L | M | N | T |
|-----------|----------|----|------|------|------|------|---|----|----|------|------|----|
| 305011 | 50110-50 | 49 | 23,0 | 28 | 30,5 | 15,3 | 8 | - | - | - | 2xM6 | 12 |
| 305037 | 80110-80 | 82 | 32,2 | 2x28 | 46,0 | 23,0 | 8 | 16 | 25 | 4xM6 | 2xM6 | 16 |



Subject to technical alterations.

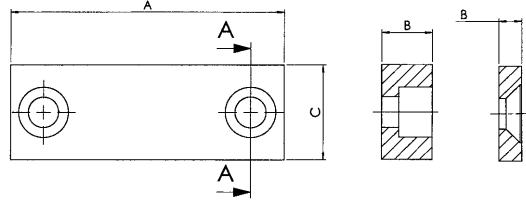
No. 6371

Gripping jaw, smooth

Hardened 60 HRC.



| Order no. | Size | for jaw width | A | B | C | Weight [g] |
|-----------|------------|---------------|----|----|----|------------|
| 300988 | 4107-50-04 | 50 | 49 | 4 | 17 | 23 |
| 301002 | 4108-50-09 | 50 | 49 | 9 | 17 | 51 |
| 301028 | 4117-80-04 | 80 | 78 | 4 | 22 | 49 |
| 301044 | 4118-80-11 | 80 | 78 | 11 | 22 | 135 |



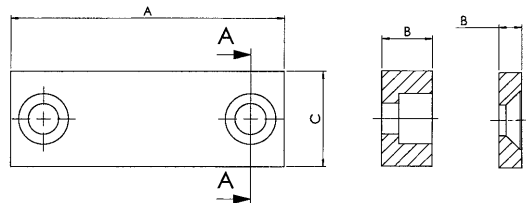
No. 6371

Gripping jaw, smooth

not hardened.



| Order no. | Size | for jaw width | A | B | C | Weight [g] |
|-----------|------------|---------------|----|----|----|------------|
| 266569 | 4103-50-09 | 50 | 49 | 9 | 17 | 51 |
| 266585 | 4104-50-12 | 50 | 49 | 12 | 17 | 67 |
| 266841 | 4113-80-11 | 80 | 78 | 11 | 22 | 133 |
| 266866 | 4114-80-18 | 80 | 78 | 18 | 22 | 217 |



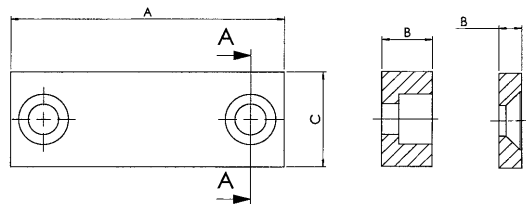
No. 6371

Gripping jaw, serrated

Hardened 60 HRC.



| Order no. | Size | for jaw width | A | B | C | Weight [g] |
|-----------|------------|---------------|----|----|----|------------|
| 300947 | 4105-50-04 | 50 | 49 | 4 | 17 | 21 |
| 266601 | 4106-50-09 | 50 | 49 | 9 | 17 | 51 |
| 300962 | 4115-80-04 | 80 | 78 | 4 | 22 | 46 |
| 266882 | 4116-80-11 | 80 | 78 | 11 | 22 | 133 |



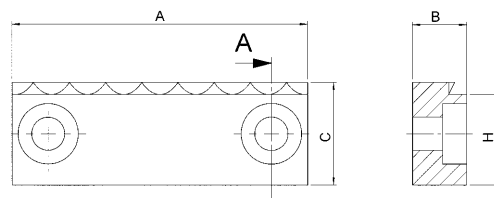
No. 6371

Gripping jaw, with claws

Hardened 60 HRC. Clamping edge height only 2 mm.



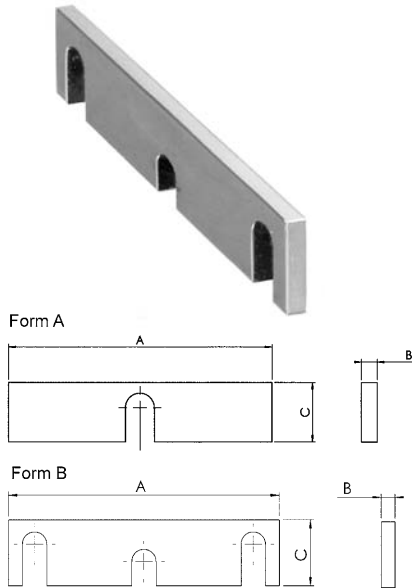
| Order no. | Size | for jaw width | DIN 7894 | A | B | C | H ±0.02 | Weight [g] |
|-----------|-----------|---------------|----------|----|----|----|---------|------------|
| 305086 | 100-50-12 | 50 | M5 x20 | 49 | 9 | 17 | 15 | 70 |
| 305094 | 100-80-12 | 80 | M6 x 20 | 78 | 12 | 22 | 19 | 150 |



Subject to technical alterations.

No. 6371

Support wedge



| Order no. | Size | for jaw width | Form | A | B | C | Weight [g] |
|-----------|-------------|---------------|------|----|---|----|------------|
| 266627 | 4201-50-011 | 50 | A | 49 | 3 | 11 | 11 |
| 266643 | 4202-50-012 | 50 | A | 49 | 3 | 12 | 12 |
| 266668 | 4203-50-013 | 50 | A | 49 | 3 | 13 | 13 |
| 266684 | 4204-50-014 | 50 | A | 49 | 3 | 14 | 16 |
| 266700 | 4205-50-015 | 50 | A | 49 | 3 | 15 | 16 |
| 266726 | 4206-50-016 | 50 | A | 49 | 3 | 17 | 17 |
| 301069 | 4351-80-012 | 80 | A | 78 | 4 | 12 | 27 |
| 300871 | 4352-80-013 | 80 | A | 78 | 4 | 13 | 30 |
| 300897 | 4353-80-014 | 80 | A | 78 | 4 | 14 | 33 |
| 300913 | 4354-80-015 | 80 | A | 78 | 4 | 15 | 34 |
| 266908 | 4355-80-016 | 80 | B | 78 | 4 | 16 | 35 |
| 266577 | 4356-80-017 | 80 | B | 78 | 4 | 17 | 36 |
| 266593 | 4357-80-018 | 80 | B | 78 | 4 | 18 | 37 |
| 266619 | 4358-80-019 | 80 | B | 78 | 4 | 19 | 40 |
| 266635 | 4359-80-020 | 80 | B | 78 | 4 | 20 | 43 |
| 266650 | 4360-80-021 | 80 | B | 78 | 4 | 21 | 46 |

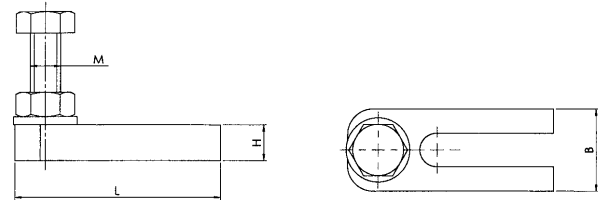
No. 6371

Lateral stop (additional)

For base, central and clamping jaw.



| Order no. | Size | B | H | L | M | Weight [g] |
|-----------|-----------|----|---|----|---|------------|
| 266742 | 4220-50 | 16 | 7 | 40 | 6 | 35 |
| 266676 | 4380-80 | 18 | 8 | 60 | 6 | 69 |
| 295006 | 4380-1-80 | 18 | 8 | 78 | 6 | 80 |



No. 6371

Chip guard



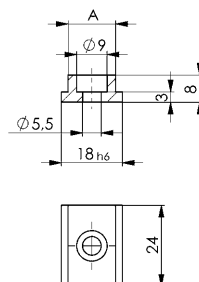
| Order no. | Size | for jaw width | Weight [g] |
|-----------|---------|---------------|------------|
| 300939 | 4221-50 | 50 | 19 |
| 300954 | 4390-80 | 80 | 43 |

No. 6371

T-nut



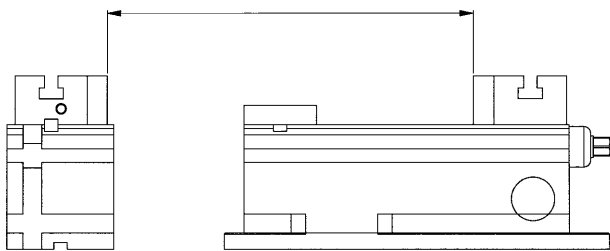
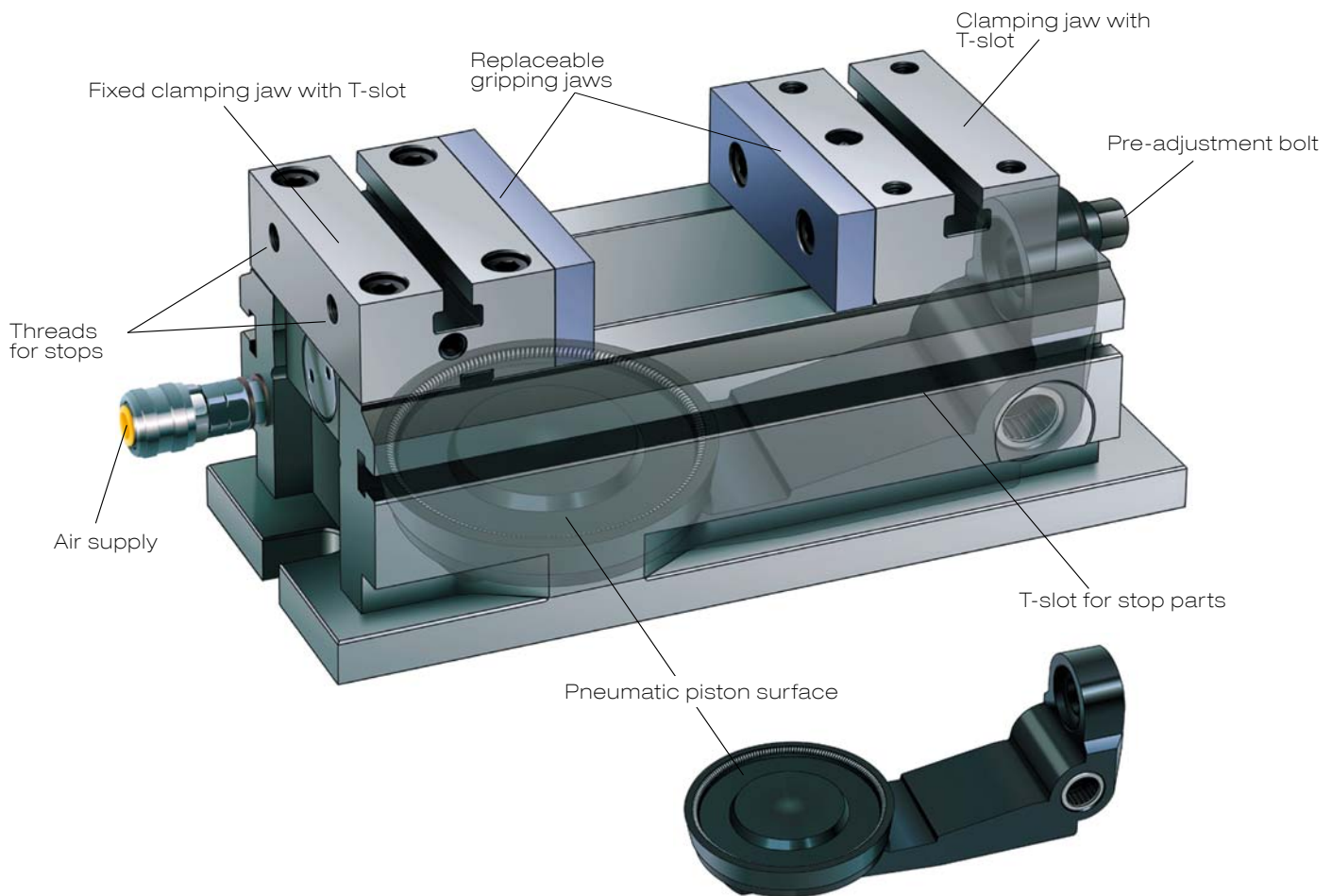
| Order no. | Size | A | Weight [g] |
|-----------|---------|----|------------|
| 301010 | 9010-10 | 10 | 16 |
| 301036 | 9012-12 | 12 | 17 |
| 301051 | 9014-14 | 14 | 18 |
| 301077 | 9018-18 | 18 | 23 |



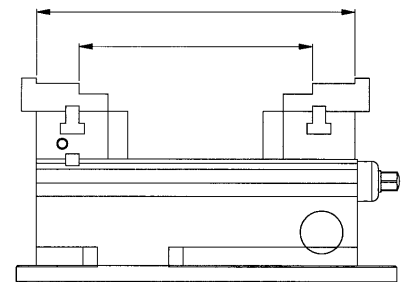
Subject to technical alterations.

PNEUMATIC VICE - THE ADVANTAGES AT A GLANCE

- > The pneumatic vice is specifically designed for the machining of single and series parts that require quick and precise clamping.
- > The clamping force is adjustable to different work-piece requirements.
- > Jaws case-hardened 60 HRC
- > Jaw widths 70 to 200 mm
- > Clamping forces up to 70 kN at 6 bar
- > The pneumatic operation significantly reduces the clamping time.
- > All supports and guides are hardened (55-60 HRC) and ground. The supports are manufactured to a height tolerance of ± 0.01 mm.
- > With 4 slots, locators, gauges and special jaws can be easily attached.



Vice with modular carrier



Vice with stepped gripping jaw

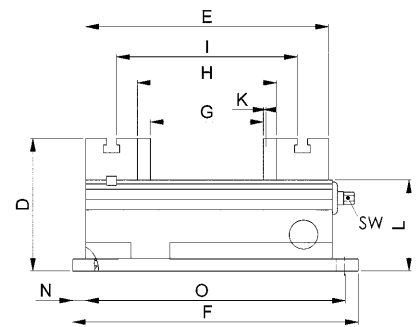
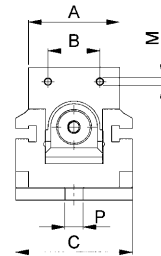
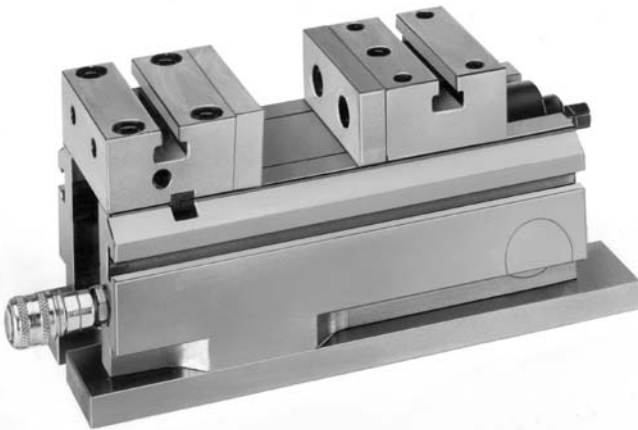
No. 6372

Base element

Hardened 56 HRC

With 1 pair of gripping jaws, smooth, hardened 60 HRC.

| Order no. | Size | Jaw width A | Clamping force at 6 bar | | Weight [Kg] |
|-----------|-----------|-------------|-------------------------|--|-------------|
| | | | [kN] | | |
| 301085 | 0700-E070 | 70 | 5 | | 8,5 |
| 301101 | 0900-E090 | 90 | 10 | | 18 |
| 301127 | 1002-E100 | 100 | 15 | | 25 |
| 301143 | 1150-E115 | 115 | 22 | | 30 |
| 301168 | 1301-E130 | 130 | 30 | | 39 |
| 301184 | 1600-E160 | 160 | 50 | | 58 |
| 301200 | 2000-E200 | 200 | 70 | | 112 |



Dimensions:

| Order no. | B | C | D | E | F | G | H | I | Stroke K | L | M | N | O | P | SW |
|-----------|-----|-----|-----|-----|-----|-----|-----|-----|----------|-----|-----|------|-----|----|----|
| 301085 | 40 | 90 | 102 | 187 | 220 | 87 | 107 | 139 | 2,0 | 70 | M6 | 10,0 | 200 | 14 | 8 |
| 301101 | 44 | 112 | 128 | 241 | 288 | 103 | 133 | 177 | 4,0 | 92 | M8 | 20,0 | 248 | 18 | 14 |
| 301127 | 46 | 128 | 145 | 260 | 317 | 86 | 116 | 178 | 4,0 | 105 | M10 | 20,0 | 277 | 18 | 14 |
| 301143 | 60 | 140 | 145 | 295 | 340 | 112 | 147 | 211 | 3,2 | 105 | M10 | 20,0 | 300 | 18 | 17 |
| 301168 | 65 | 160 | 155 | 315 | 370 | 127 | 163 | 229 | 3,5 | 110 | M10 | 20,0 | 330 | 18 | 17 |
| 301184 | 80 | 196 | 160 | 368 | 403 | 164 | 200 | 272 | 4,0 | 115 | M10 | 18,5 | 366 | 18 | 17 |
| 301200 | 100 | 236 | 195 | 475 | 480 | 235 | 275 | 361 | 4,5 | 135 | M12 | 20,0 | 440 | 18 | 17 |



Subject to technical alterations.

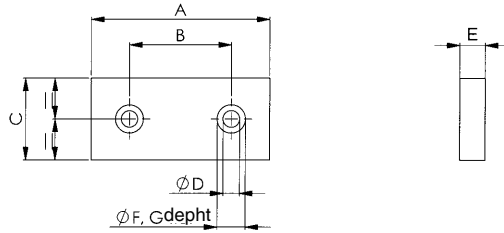
No. 6372

Gripping jaw, smooth

Hardened 60 HRC.



| Order no. | Size | A | B | C | dia. D | E | dia. F | G | Weight [g] |
|-----------|-----------|-----|-----|----|--------|----|--------|------|------------|
| 301176 | 4048-E070 | 70 | 40 | 32 | 7,0 | 10 | 11 | 6,5 | 232 |
| 301192 | 4041-E090 | 90 | 44 | 36 | 9,0 | 15 | 14 | 9,0 | 352 |
| 301218 | 4042-E100 | 100 | 46 | 40 | 11,0 | 15 | 17 | 11,0 | 423 |
| 301234 | 4043-E115 | 115 | 60 | 40 | 11,0 | 15 | 17 | 10,5 | 493 |
| 301259 | 4044-E130 | 130 | 65 | 45 | 11,0 | 18 | 17 | 11,0 | 771 |
| 301275 | 4045-E160 | 160 | 80 | 45 | 11,0 | 18 | 17 | 11,0 | 950 |
| 301291 | 4046-E200 | 200 | 100 | 60 | 13,0 | 20 | 19 | 13,0 | 1790 |



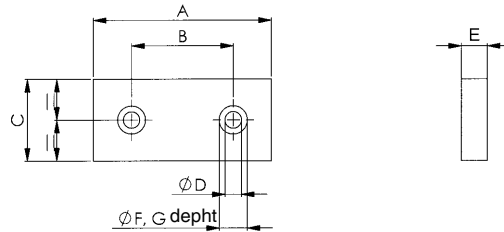
No. 6372

Gripping jaw, serrated

Hardened 60 HRC.



| Order no. | Size | A | B | C | dia. D | E | dia. F | G | Weight [g] |
|-----------|-----------|-----|-----|----|--------|----|--------|------|------------|
| 301317 | 4071-E070 | 70 | 40 | 32 | 7,0 | 10 | 11 | 6,5 | 262 |
| 301333 | 4073-E090 | 90 | 44 | 36 | 8,5 | 15 | 14 | 9,0 | 322 |
| 301358 | 4074-E100 | 100 | 46 | 40 | 11,0 | 15 | 17 | 11,0 | 392 |
| 301374 | 4075-E115 | 115 | 60 | 40 | 11,0 | 15 | 17 | 10,5 | 455 |
| 301390 | 4076-E130 | 130 | 65 | 45 | 11,0 | 18 | 17 | 11,0 | 720 |
| 301416 | 4077-E160 | 160 | 80 | 45 | 11,0 | 18 | 17 | 11,0 | 896 |
| 301432 | 4078-E200 | 200 | 100 | 60 | 13,0 | 20 | 19 | 13,0 | 1661 |



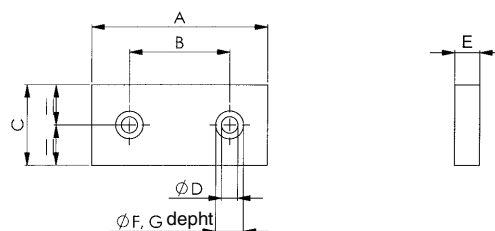
No. 6372

Gripping jaw, smooth

Not hardened, for individual processing.



| Order no. | Size | A | B | C ±0.01 | dia. D | E ±0.01 | dia. F | G | Weight [g] |
|-----------|-----------|-----|-----|---------|--------|---------|--------|------|------------|
| 301580 | 4050-E070 | 70 | 40 | 32 | 7,0 | 10 | 11 | 6,5 | 235 |
| 301606 | 4001-E090 | 90 | 11 | 36 | 9,0 | 15 | 14 | 9,0 | 359 |
| 301622 | 4002-E100 | 100 | 46 | 40 | 11,0 | 15 | 17 | 11,0 | 426 |
| 301648 | 4003-E115 | 115 | 60 | 40 | 11,0 | 15 | 17 | 10,5 | 495 |
| 301663 | 4004-E130 | 130 | 65 | 45 | 11,0 | 18 | 17 | 11,0 | 775 |
| 301689 | 4005-E160 | 160 | 80 | 45 | 11,0 | 18 | 17 | 11,0 | 955 |
| 301705 | 4006-E200 | 200 | 100 | 60 | 13,0 | 20 | 19 | 13,0 | 1790 |



Subject to technical alterations.

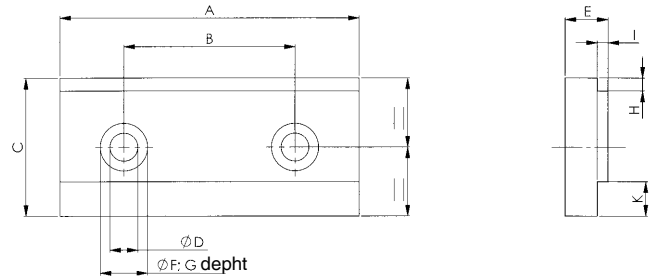
No. 6372

Gripping jaw, stepped

Hardened 60 HRC.



| Order no. | Size | A | B | C ±0.01 | dia. D | E ±0.01 | dia. F | G | H ±0.01 | I | K ±0.01 | Weight [g] |
|-----------|-----------|-----|-----|---------|--------|---------|--------|------|---------|-----|---------|------------|
| 301440 | 4061-E070 | 70 | 40 | 32 | 7,0 | 10 | 11 | 6,5 | 3 | 2,5 | 8 | 262 |
| 301465 | 4007-E090 | 90 | 44 | 36 | 8,5 | 15 | 14 | 9,0 | 4 | 3 | 9 | 322 |
| 301481 | 4008-E100 | 100 | 46 | 40 | 11,0 | 15 | 17 | 11,0 | 4 | 3 | 9 | 392 |
| 301507 | 4009-E115 | 115 | 60 | 40 | 11,0 | 15 | 17 | 11,0 | 4 | 3 | 9 | 455 |
| 301523 | 4010-E130 | 130 | 65 | 45 | 11,0 | 18 | 17 | 11,0 | 4 | 3 | 13 | 720 |
| 301549 | 4011-E160 | 160 | 80 | 45 | 11,0 | 18 | 17 | 11,0 | 4 | 3 | 13 | 896 |
| 301564 | 4012-E200 | 200 | 100 | 60 | 13,0 | 18 | 19 | 13,0 | 6 | 4 | 16 | 1661 |



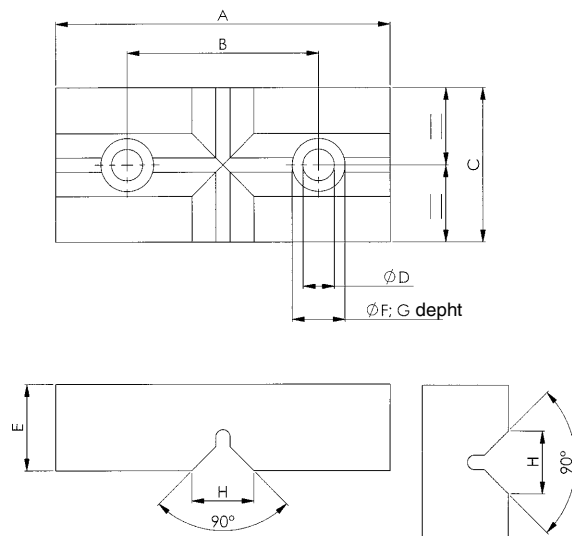
No. 6372

Gripping jaw, V-block

Hardened 60 HRC.



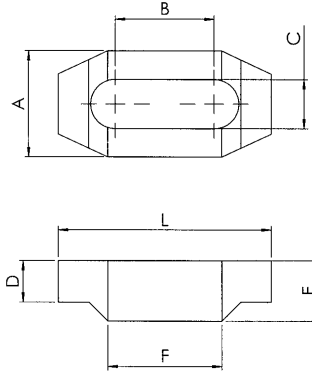
| Order no. | Size | A | B | C ±0.01 | dia. D | E ±0.01 | F | G | H | Weight [g] |
|-----------|-----------|-----|-----|---------|--------|---------|------|----|------|------------|
| 301515 | 4054-E070 | 70 | 40 | 32 | 7,0 | 18 | 11,0 | 14 | 13,3 | 262 |
| 301531 | 4013-E090 | 90 | 44 | 36 | 9,0 | 26 | 14,0 | 20 | 20,3 | 532 |
| 301556 | 4014-E100 | 100 | 46 | 40 | 10,5 | 28 | 17,0 | 22 | 20,3 | 708 |
| 301572 | 4015-E115 | 115 | 60 | 40 | 11,5 | 28 | 17,5 | 22 | 20,3 | 822 |
| 301598 | 4016-E130 | 130 | 65 | 45 | 11,0 | 28 | 17,0 | 22 | 20,3 | 1079 |
| 301614 | 4017-E160 | 160 | 80 | 45 | 11,5 | 28 | 17,5 | 21 | 24,3 | 1296 |
| 301630 | 4018-E200 | 200 | 100 | 60 | 13,0 | 28 | 19,0 | 22 | 23,8 | 2260 |



No. 6372

Double-ended clamp

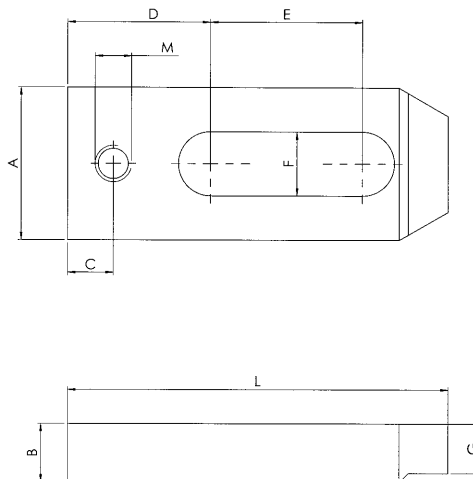
| Order no. | Size | A | B | C | D | E | F | L | Weight [g] |
|-----------|----------------|----|----|----|----|----|----|----|------------|
| 301804 | 5003-E070-E090 | 28 | 26 | 13 | 11 | 16 | 30 | 56 | 135 |
| 301796 | 5001-E100-E200 | 38 | 30 | 17 | 16 | 18 | 34 | 60 | 226 |



No. 6372

Straight clamp

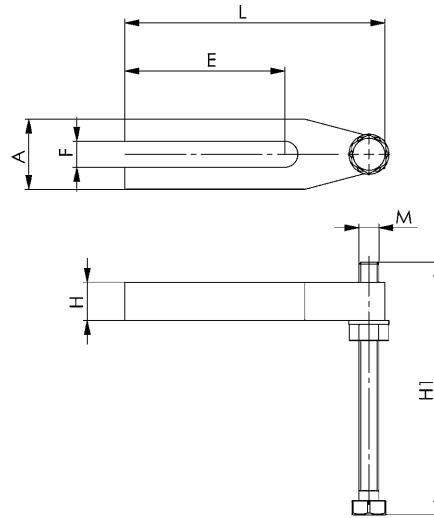
| Order no. | Size | A | B | C | D | E | F | G | L | M | Weight [g] |
|-----------|----------------|----|----|----|----|----|----|----|----|----|------------|
| 301846 | 5006-E070-E090 | 26 | 16 | 12 | 33 | 25 | 13 | 11 | 87 | 12 | 278 |
| 301820 | 5002-E100-E200 | 40 | 19 | 13 | 40 | 33 | 17 | 16 | 98 | 12 | 524 |



No. 6372

Stop

| Order no. | Size | A | C | E | F | H | H1 | L | M | Weight [g] |
|-----------|------|----|---|----|----|----|-----|-----|-----|------------|
| 301861 | 5005 | 35 | 8 | 80 | 13 | 15 | 126 | 130 | M10 | 643 |



No. 6372

Pneumatic valve

| Order no. | Size | Weight [g] |
|-----------|------|------------|
| 301903 | 6001 | 1037 |



No. 6372

Air filter and pressure regulator

| Order no. | Size | Weight [g] |
|-----------|------|------------|
| 301929 | 6002 | 1079 |



No. 6376G

Clamping rail

Max. clamping force per clamping position 30 kN



| Order no. | Size | B | dia. D1 +0.01 | dia. D2 | H ±0.02 | H1 | H2 | L | M | S1 +0.03 | SM1 ±0.01 | SM2 ±0.01 | Weight [g] |
|-----------|--------|----|------------------|---------|------------|----|----|-----|-----|-------------|--------------|--------------|---------------|
| 429035 | 50x300 | 50 | 25 | 13 | 80 | 10 | 26 | 300 | M12 | 5,5 | 50 | 100 | 6680 |
| 429050 | 50x400 | 50 | 25 | 13 | 80 | 10 | 26 | 400 | M12 | 5,5 | 50 | 150 | 9050 |
| 429076 | 80x400 | 80 | 25 | 13 | 80 | 10 | 26 | 400 | M12 | 5,5 | 50 | 150 | 16480 |
| 429092 | 50x500 | 50 | 25 | 13 | 80 | 10 | 26 | 500 | M12 | 5,5 | 50 | 200 | 11430 |
| 429118 | 80x500 | 80 | 25 | 13 | 80 | 10 | 26 | 500 | M12 | 5,5 | 50 | 200 | 20780 |
| 429134 | 80x600 | 80 | 25 | 13 | 80 | 10 | 26 | 600 | M12 | 5,5 | 50 | 250 | 24950 |

Design:

Material: Case-hardened steel 21MnCr5, plasma-nitrided. Hardness 58 HRC.

Designed for the following mounting options on the machine table:

1. Lateral clamping rim for clamping shoe order no. 429258.
2. Through-hole in the clamping rail for socket head screw DIN ISO 4762-M12 for mounting using bolt and slot nut.
3. Prepared for clamping with the AMF Zero Point clamping system. Mounting holes at a distance of 50 or 100 mm for the pull-stud size 20.

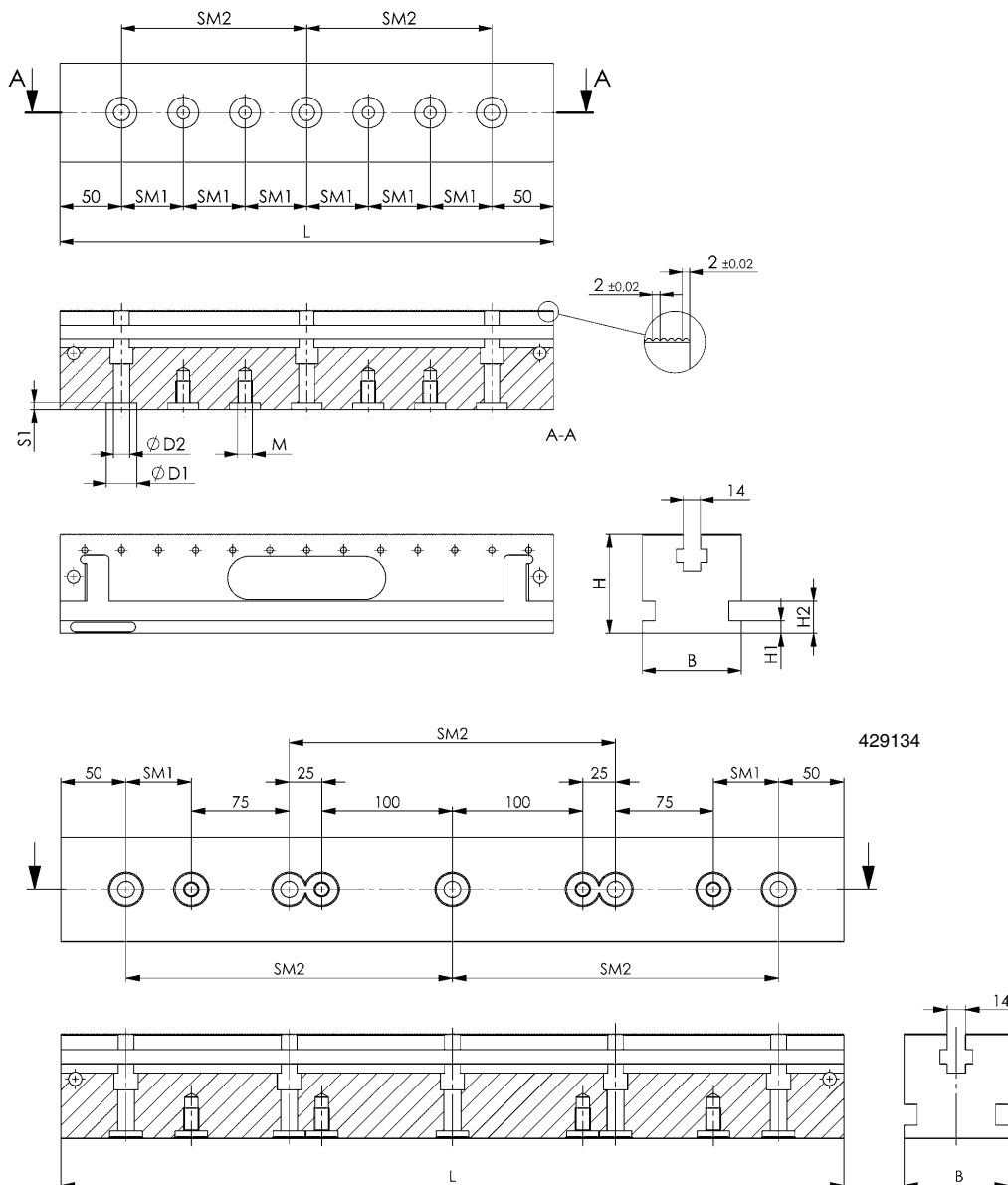
Other mounting holes, for example pull-stud size 10 or size 40, can be supplied any time on request. Positioning steps on the clamping rail grating is possible at intervals of 2 mm.

Application:

Modularly constructed clamping system, which has its advantages in the versatile application possibilities.

Optionally designed for one or more workpieces.

For rapid clamping of workpieces for machine processing. Through use of a wide array of fixed stops and wedge clamps, this clamping system is adapted to your needs.



Subject to technical alterations.



No. 6376K

Wedge clamp, smooth

With fastening bolt and T-nut.



| Order no. | Size | A min. | A max. | B | H min. | H max. | L | Md max. [Nm] | Clamping force F [kN] | Weight [g] |
|-----------|------|--------|--------|----|--------|--------|----|-----------------|--------------------------|---------------|
| 429506 | 30 | 43,5 | 51,0 | 30 | 22 | 29,5 | 44 | 65 | 30 | 300 |
| 429522 | 40 | 43,5 | 51,0 | 40 | 22 | 29,5 | 44 | 65 | 30 | 380 |
| 429548 | 50 | 43,5 | 51,0 | 50 | 22 | 29,5 | 44 | 65 | 30 | 450 |
| 429563 | 72 | 46,5 | 57,5 | 72 | 29 | 39,0 | 44 | 65 | 30 | 865 |

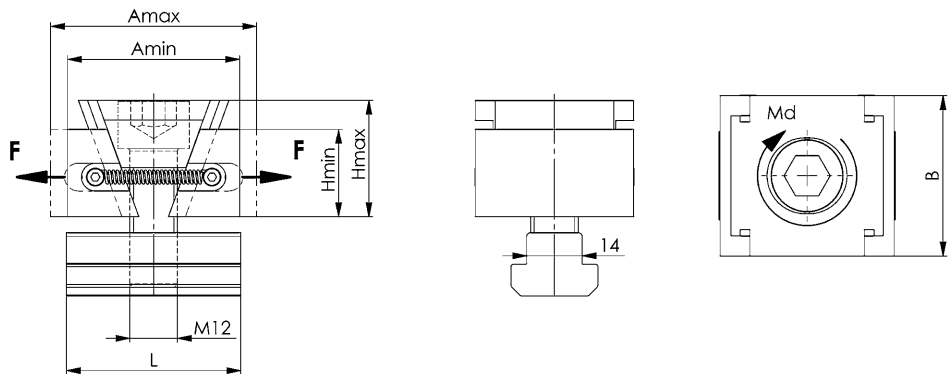
Design:

Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



No. 6376KG

Wedge clamp, serrated

With fastening bolt and T-nut.



| Order no. | Size | A min. | A max. | B | H min. | H max. | L | Md max. [Nm] | Clamping force F [kN] | Weight [g] |
|-----------|------|--------|--------|----|--------|--------|----|-----------------|--------------------------|---------------|
| 429589 | 30 | 43,5 | 51,0 | 30 | 22 | 29,5 | 44 | 65 | 30 | 300 |
| 429605 | 40 | 43,5 | 51,0 | 40 | 22 | 29,5 | 44 | 65 | 30 | 378 |
| 429621 | 50 | 43,5 | 51,0 | 50 | 22 | 29,5 | 44 | 65 | 30 | 448 |
| 429647 | 72 | 46,5 | 57,5 | 72 | 29 | 39,0 | 44 | 65 | 30 | 855 |

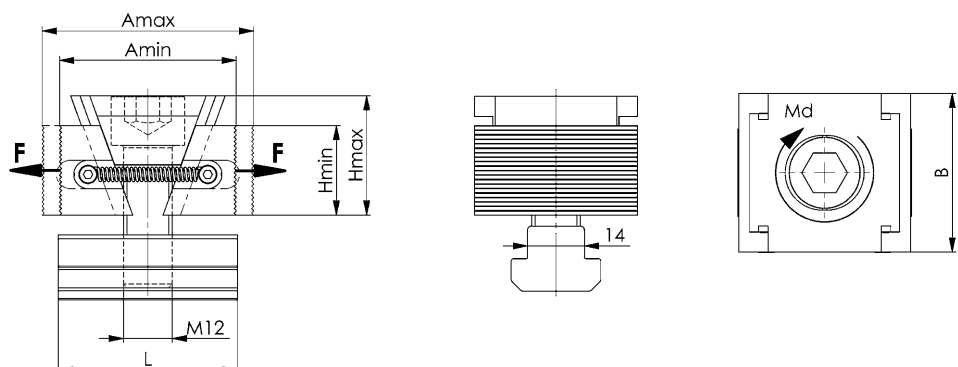
Design:

Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.

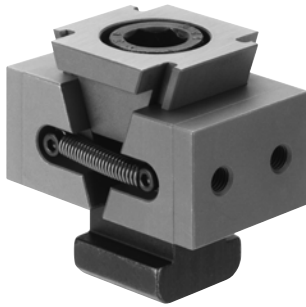


Subject to technical alterations.

No. 6376KW

Wedge clamp with measurement

With fastening bolt and T-nut.



| Order no. | Size | A min. * | A max. * | B | B1 | G | H min. | H max. | H1 | L | Md max. [Nm] | Clamping force F [kN] | Weight [g] |
|-----------|------|----------|----------|----|----|----|--------|--------|------|----|--------------|-----------------------|------------|
| 429662 | 30 | 53,5 | 61,5 | 30 | 15 | M5 | 22 | 29,5 | 11,0 | 44 | 65 | 30 | 350 |
| 429688 | 40 | 53,5 | 61,5 | 40 | 20 | M5 | 22 | 29,5 | 11,0 | 44 | 65 | 30 | 490 |
| 429704 | 50 | 53,5 | 61,5 | 50 | 25 | M5 | 22 | 29,5 | 11,0 | 44 | 65 | 30 | 535 |
| 429373 | 72 | 56,5 | 68,0 | 72 | 36 | M6 | 29 | 39,0 | 14,5 | 44 | 65 | 30 | 1020 |

* Includes tolerance for inserting special geometries (5 mm).

Design:

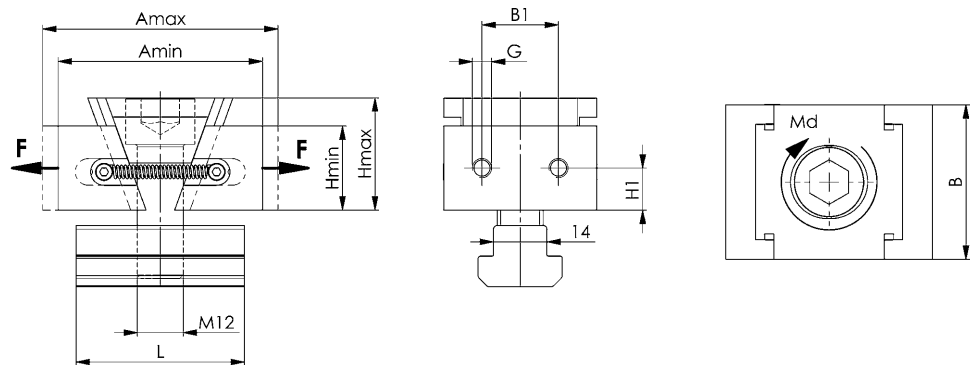
Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Wedge clamp with tolerance for inserting special geometries.

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



No. 6376KK

Wedge clamp

With claw jaws, 2 mm lower clamping step.

With fastening bolt and T-nut.



| Order no. | Size | A min. | A max. | B | B1 | G | H min. | H max. | H1 | H3 | L | Md max. [Nm] | Clamping force F [kN] | Weight [g] |
|-----------|------|--------|--------|----|----|----|--------|--------|------|----|----|--------------|-----------------------|------------|
| 429399 | 30 | 50 | 57,5 | 30 | 15 | M5 | 22 | 29,0 | 11,0 | 20 | 44 | 65 | 30 | 350 |
| 429415 | 40 | 50 | 57,5 | 40 | 20 | M5 | 22 | 29,0 | 11,0 | 20 | 44 | 65 | 30 | 440 |
| 429431 | 50 | 50 | 57,5 | 50 | 25 | M5 | 22 | 29,0 | 11,0 | 20 | 44 | 65 | 30 | 530 |
| 429456 | 72 | 53 | 64,0 | 72 | 36 | M6 | 29 | 38,5 | 14,5 | 27 | 44 | 65 | 30 | 1015 |

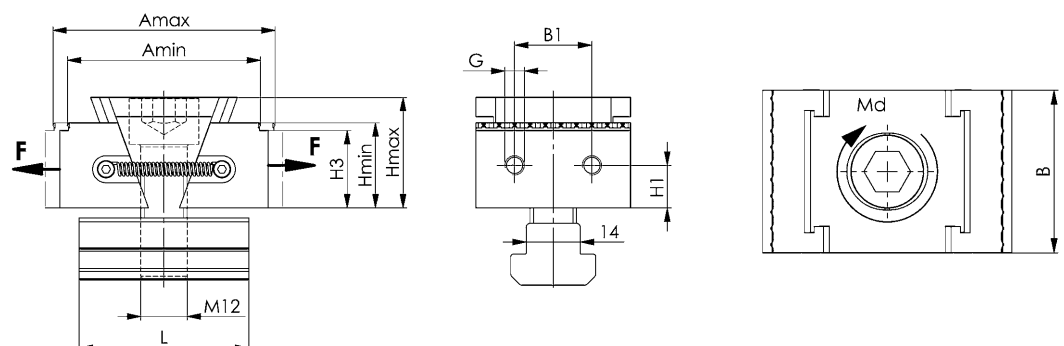
Design:

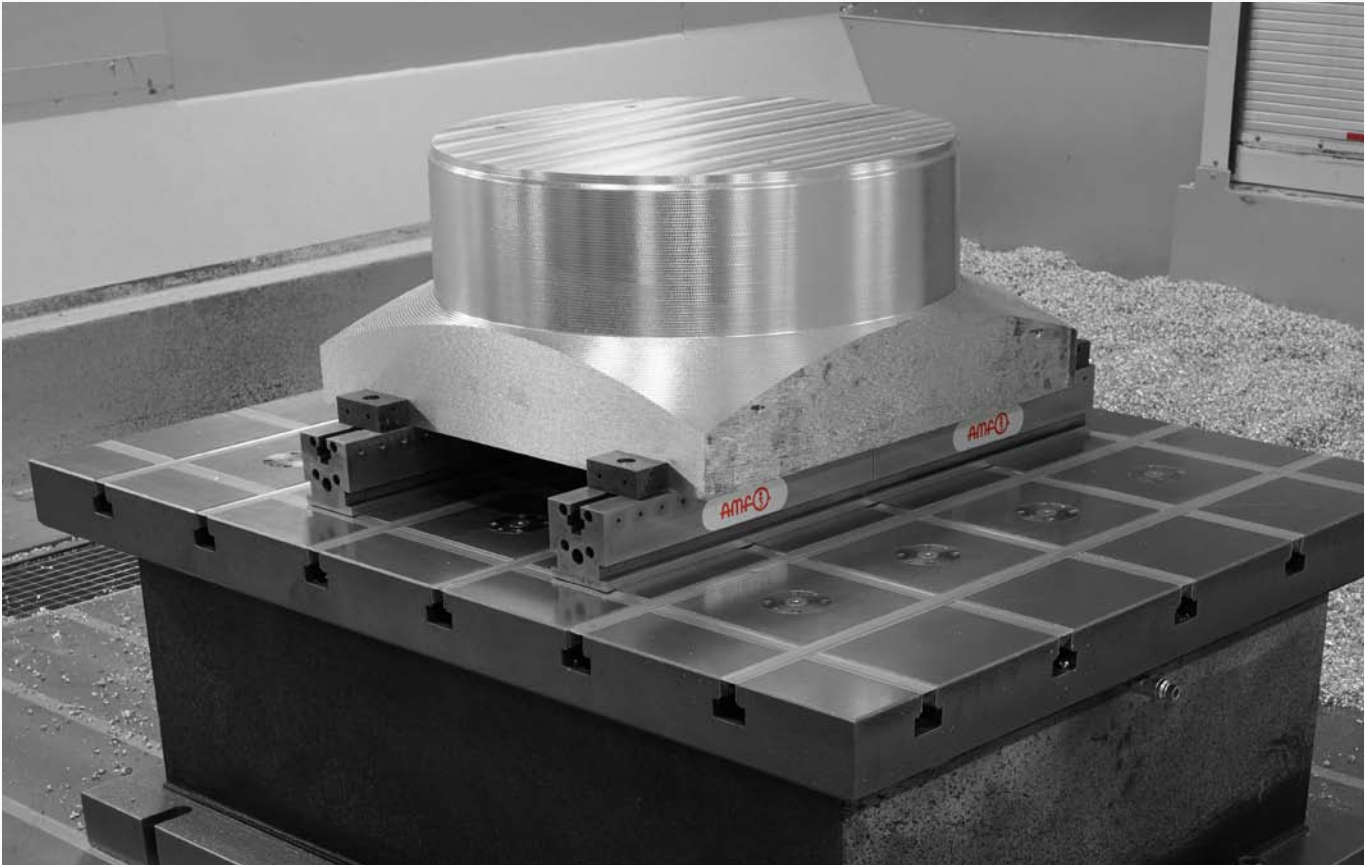
Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.





Subject to technical alterations.

No. 6376B

Fixed clamping jaw, smooth

With fastening bolt and T-nut.



| Order no. | Size | A | B | B1 | G | H | H1 | H2 | L | Weight [g] |
|-----------|------|----|----|----|----|------|------|------|----|------------|
| 429274 | 30 | 42 | 30 | 15 | M5 | 22,4 | 11,4 | 14,4 | 22 | 260 |
| 429290 | 40 | 42 | 40 | 20 | M5 | 22,4 | 11,4 | 14,4 | 22 | 325 |
| 429316 | 50 | 42 | 50 | 25 | M5 | 22,4 | 11,4 | 14,4 | 22 | 400 |
| 429332 | 72 | 42 | 72 | 36 | M6 | 29,4 | 14,9 | 21,4 | 44 | 760 |

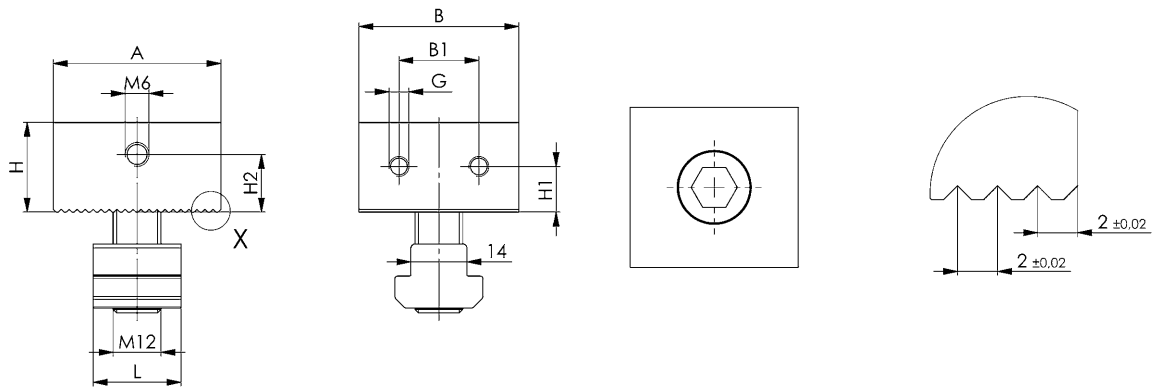
Design:

Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the 2 mm serration. Workpieces can be positioned and clamped with great clamping force.



No. 6376BG

Fixed clamping jaw, serrated

With fastening bolt and T-nut.



| Order no. | Size | A | B | H | H2 | L | Weight [g] |
|-----------|------|----|----|------|------|----|------------|
| 429357 | 30 | 42 | 30 | 22,4 | 14,4 | 22 | 260 |
| 429365 | 40 | 42 | 40 | 22,4 | 14,4 | 22 | 330 |
| 429381 | 50 | 42 | 50 | 22,4 | 14,4 | 22 | 400 |
| 429407 | 72 | 42 | 72 | 29,4 | 21,4 | 44 | 760 |

Design:

Material: case-hardened steel 21MnCr5

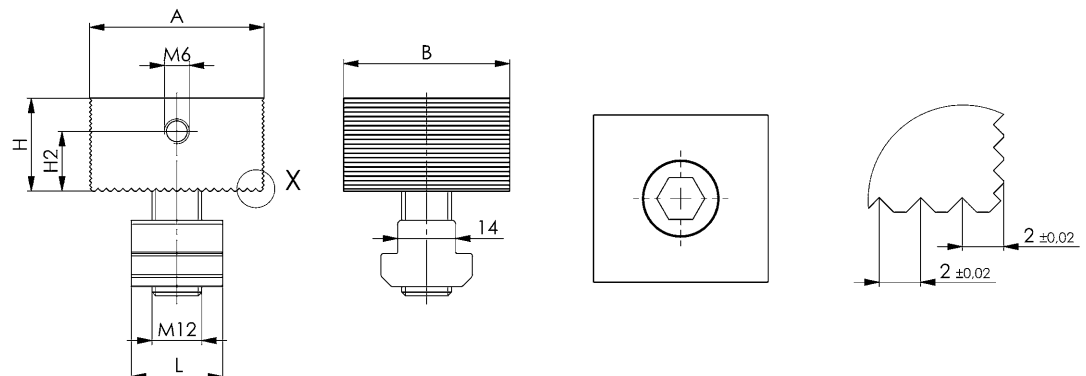
Highly tempered and case hardened to 52 HRC.

Hardness depth 0.6 mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the 2 mm serration.

Workpieces can be positioned and clamped with great clamping force.



Subject to technical alterations.

No. 6376BK

Fixed clamping jaw with claw jaws

2 mm lower clamping step.
With fastening bolt and T-nut.



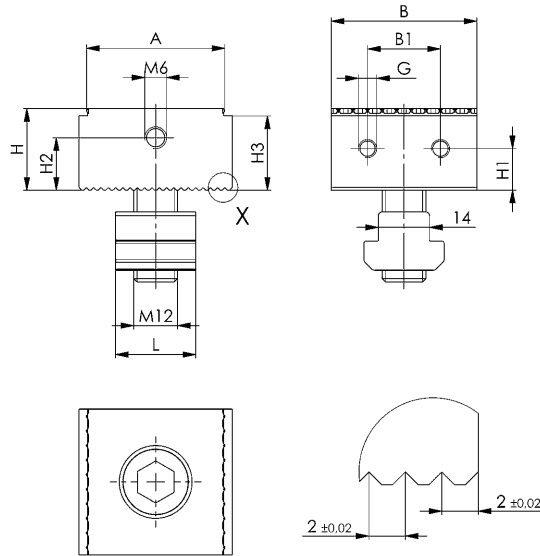
| Order no. | Size | A | B | B1 | G | H | H1 | H2 | H3 | L | Weight [g] |
|-----------|------|----|----|----|----|------|------|------|------|----|------------|
| 429423 | 30 | 38 | 30 | 15 | M5 | 22,4 | 11,4 | 14,4 | 20,4 | 22 | 250 |
| 429449 | 40 | 38 | 40 | 20 | M5 | 22,4 | 11,4 | 14,4 | 20,4 | 22 | 320 |
| 429464 | 50 | 38 | 50 | 25 | M5 | 22,4 | 11,4 | 14,4 | 20,4 | 22 | 392 |
| 429480 | 72 | 38 | 72 | 36 | M6 | 29,4 | 14,9 | 21,4 | 27,4 | 44 | 752 |

Design:

Material: case-hardened steel 21MnCr5
Highly tempered and case hardened to 52 HRC. Hardness depth 0.6mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the 2 mm serration.
Workpieces can be positioned and clamped with great clamping force.



No. 6376VB

Front jaws

Complete with fastening bolts.



| Order no. | A | B | D | H | H1 | L1 | L2 | Weight [g] |
|-----------|----|----|---|----|----|----|----|------------|
| 429696 | 11 | 50 | 6 | 22 | 25 | 15 | 25 | 36 |
| 429712 | 22 | 72 | 7 | 29 | 32 | 21 | 36 | 152 |

Design:

Aluminium

Application:

Aluminium front jaws for cutting customised contours.

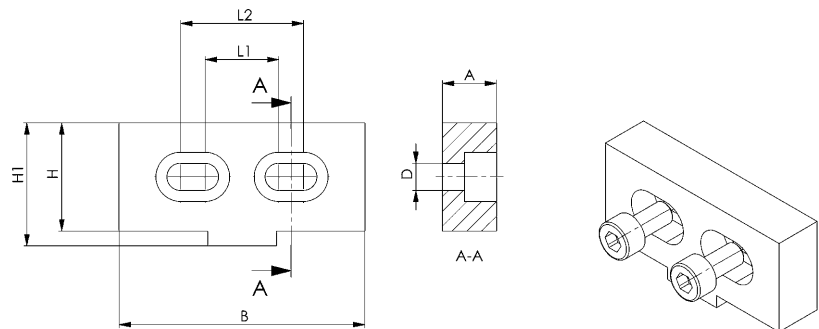
Suitable for:

Order no. 429696: Wedge clamp no. 6376KW-30, -40 and -50

Fixed stop no. 6376B-30, -40 and -50.

Order no. 429712: Wedge clamp no. 6376KW-72

Fixed stop no. 6376B-72

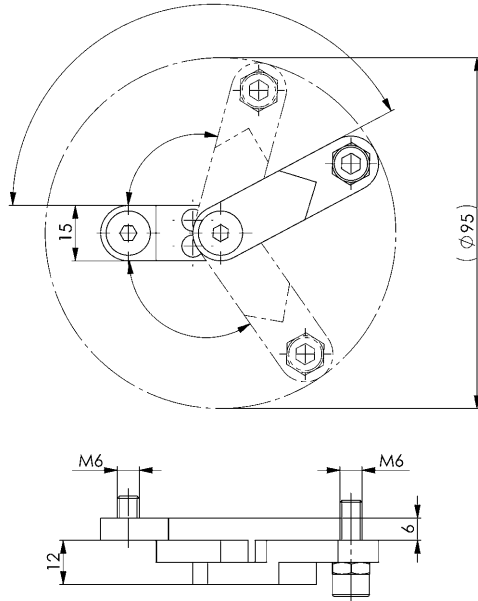


Subject to technical alterations.

No. 6376AV

Stop, flexible

With fastening bolt M6 and adjusting screw M6.



| Order no. | For clamping jaw | Weight [g] |
|-----------|-----------------------|------------|
| 429175 | 6376B, 6376BG, 6376BK | 150 |

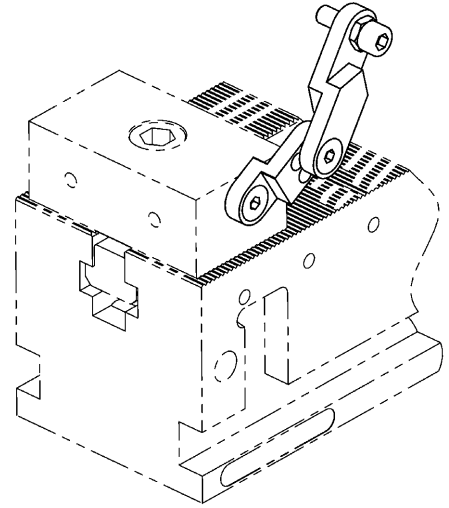
Design:

Aluminium

Application:

Lateral stop for positioning workpieces.

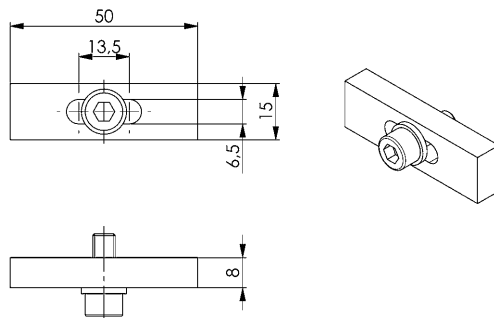
Stop is screwed to the fixed jaw and can be adjusted in two directions through its joint.



No. 6376AF

Stop, fixed

With fastening bolt and disc.



| Order no. | For clamping jaw | Weight [g] |
|-----------|-----------------------|------------|
| 429191 | 6376B, 6376BG, 6376BK | 40 |

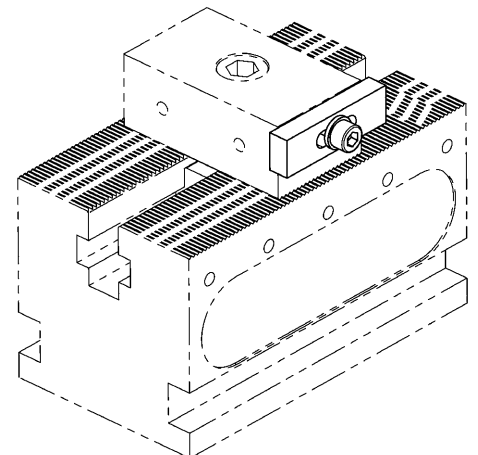
Design:

Aluminium

Application:

Lateral stop for positioning workpieces.

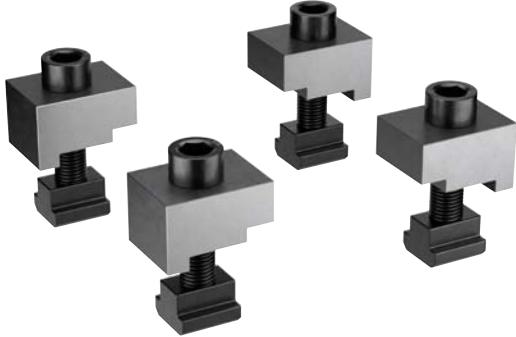
Stop is screwed to the fixed jaw and can be moved.



No. 6376SP

Clamping jaws

4 clamping jaws per packaging unit.
With fastening bolts and nuts for T-slots.



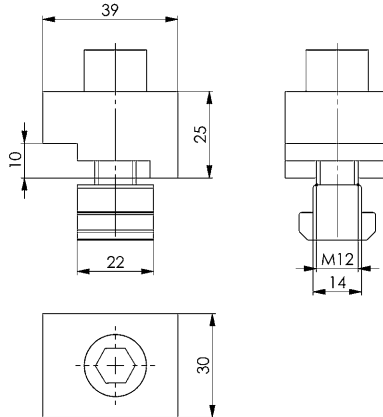
| Order no. | For clamping rail | Weight [g] |
|-----------|-------------------|------------|
| 429258 | 6376G | 1010 |

Design:

Tempered steel, burnished.

Application:

For mounting of the clamping rail on the machine table with slots.



No. 6376PB

Positioning socket



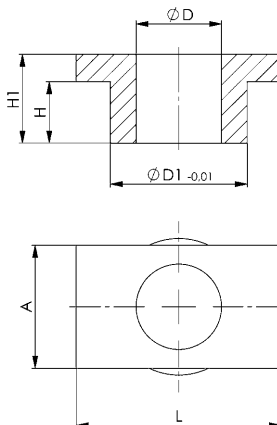
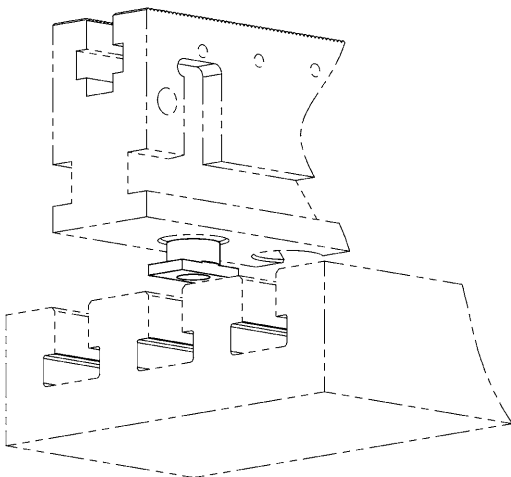
| Order no. | A | dia. D | dia. D1 | H | H1 | L | Weight [g] |
|-----------|----|--------|---------|---|----|----|------------|
| 429233 | 18 | 12,5 | 20 | 9 | 13 | 30 | 26 |
| 429217 | 14 | 12,5 | 20 | 9 | 13 | 30 | 23 |

Design:

Tempered steel, burnished.

Application:

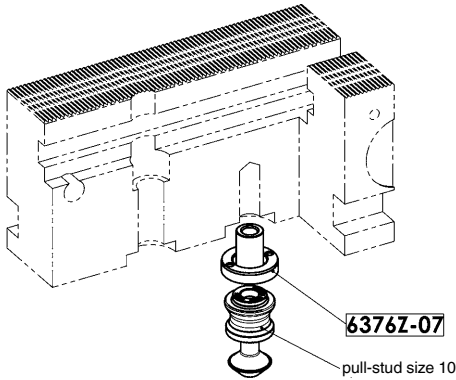
Positioning socket for simplified orientation of the clamping rail with width 50 on the machine table. All clamping rails are equipped on the bottom with fittings for the positioning sockets. As a result, the clamping rails can be oriented on the machine table quickly and easily.



No. 6376Z

Adapter set for pull-stud size 10

With adapter sleeve and positioning socket.



| Order no. | dia. D1 | dia. D2 | S1 | H | Weight [g] |
|-----------|---------|---------|-----|----|------------|
| 430207 | 25 | 15 | 5,5 | 19 | 23 |

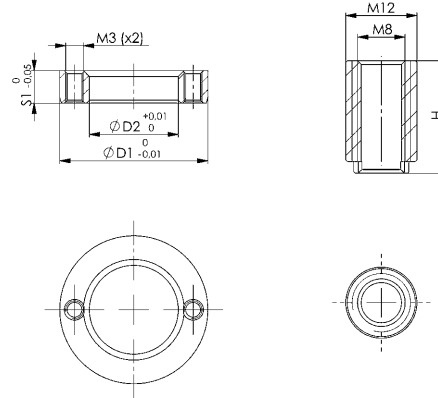
Design:

For blind hole thread and clamping rail, see article no. 6376G.

The threaded sleeve is produced from alloyed heat-treated steel, the adapter ring from case-hardened steel.

Application:

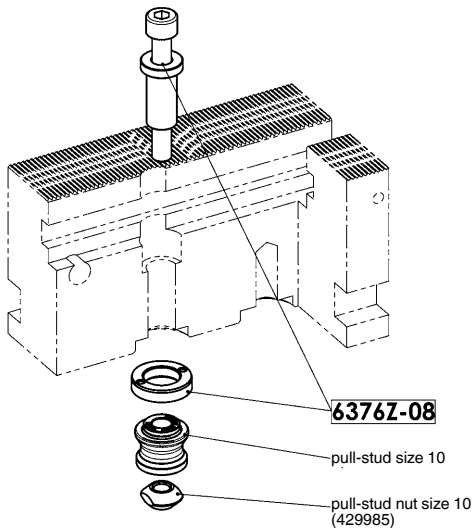
Adapter kit for reducing the locating bore from pull-stud size 20 to size 10.



No. 6376Z

Adapter set for pull-stud size 10

With cylinder screw, adapter sleeve and positioning socket.



| Order no. | dia. D | dia. D1 | dia. D2 | dia. D3 | H | S1 | Weight [g] |
|-----------|--------|---------|---------|---------|----|-----|------------|
| 430223 | 17,5 | 25 | 15 | 12,5 | 30 | 5,5 | 62 |

Design:

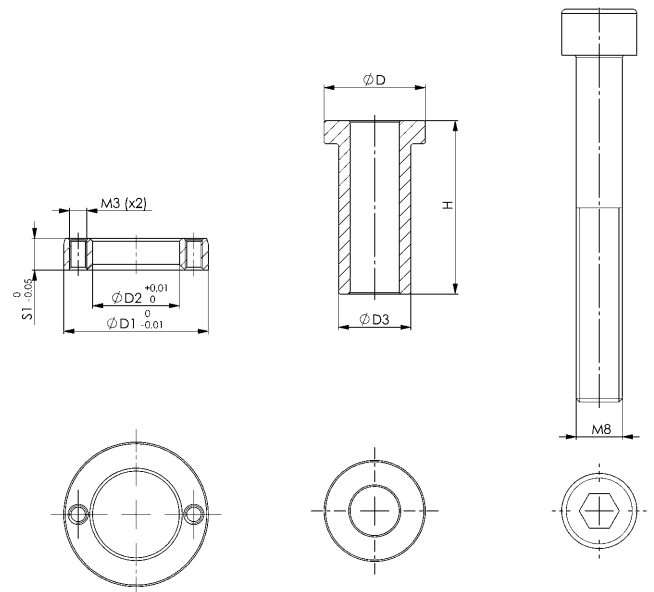
For through-bores in the clamping rail, see Item No. 6376G.

The threaded sleeve is produced from alloyed heat-treated steel, the adapter ring from case-hardened steel.

The fastening bolt conforms to strength class 10.9.

Application:

Adapter kit for reducing the locating bore from pull-stud size 20 to size 10.

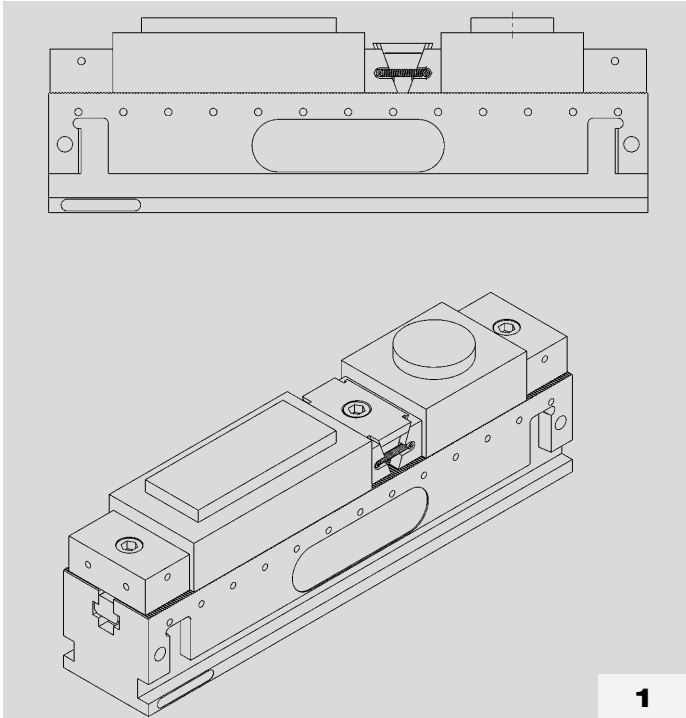




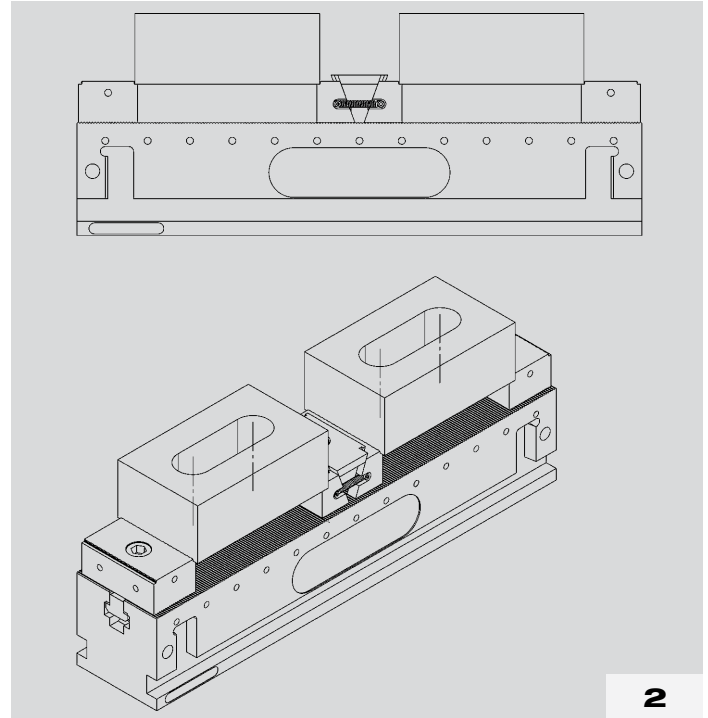
Subject to technical alterations.

Application examples

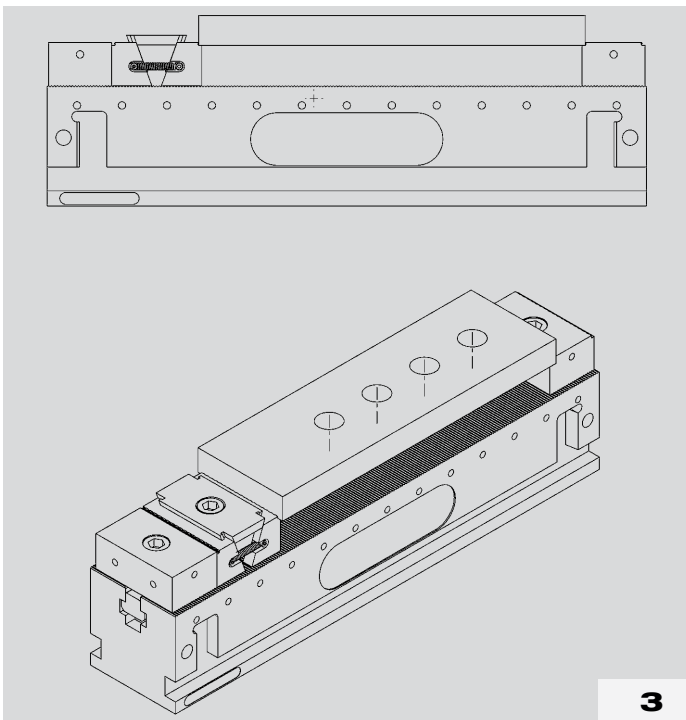
- > **1** clamping of workpieces with smooth clamping jaws
- > **2** clamping of workpieces with claw jaws
- > **3** clamping of a workpiece with claw jaws
- > **4** clamping of dissimilar workpieces with claw jaws



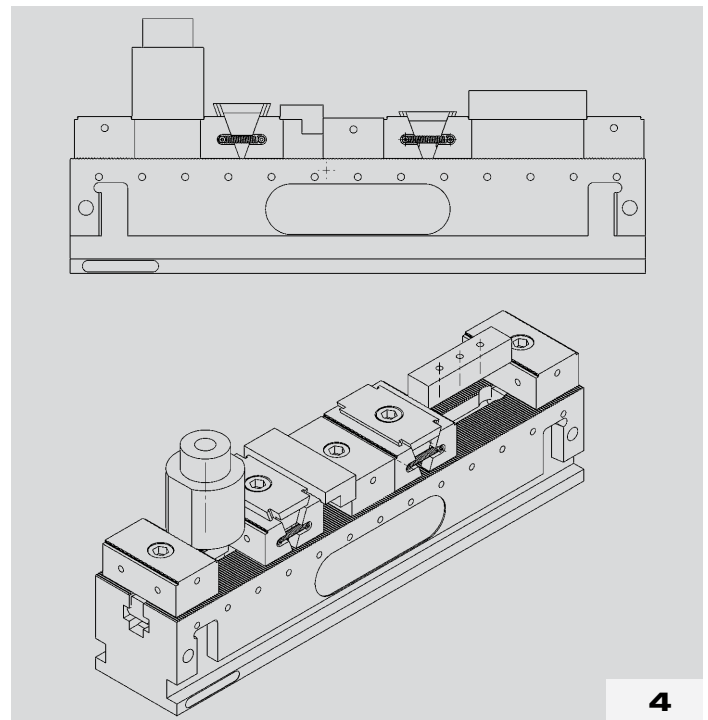
1



2



3



4

No. 6376A

5-axis clamp design

Serration top and bottom
With fastening bolt and T-nut.

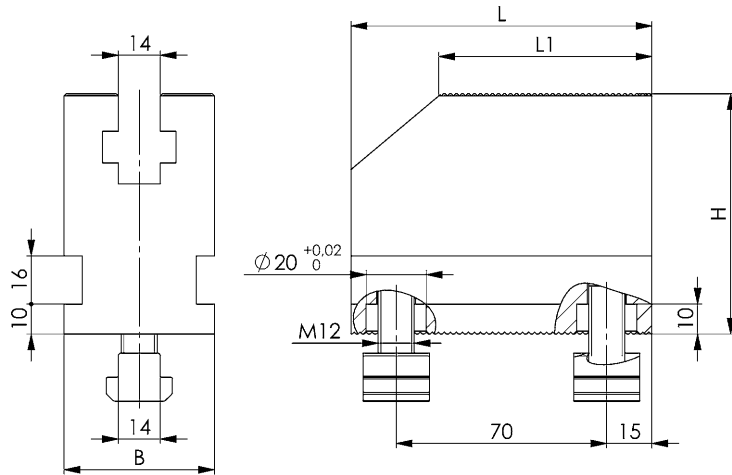
| Order no. | Size | B | H | L | L1 | Weight [g] |
|-----------|--------|----|----|-----|----|------------|
| 429472 | 50x100 | 50 | 80 | 100 | 71 | 2480 |
| 429498 | 80x100 | 80 | 80 | 100 | 71 | 4080 |

Design:

Material: case-hardened steel 21MnCr5, plasma-nitrided hardness 58 HRC.

Application:

The structure for 5-sided machining is mounted on the clamping rail no. 6376G. Through the serration, this structure grips the clamping rail positively interlocked and can be supplemented, for example, with wedge clamp no. 6376KA or no. 6376KKA and fixed stop no. 6376BA or no. 6376KA. This structure is suitable for converting the multiple clamping system into a clamping means for 5-sided machining. This conversion can be made with just a few hand movements.

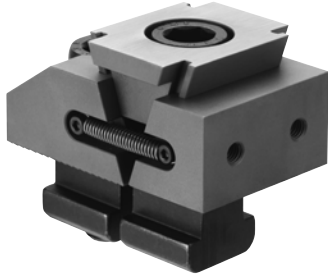


Subject to technical alterations.

No. 6376KA

Wedge clamp with fixed jaw, smooth

For 5-axis clamp.
With fastening bolt and T-nut.



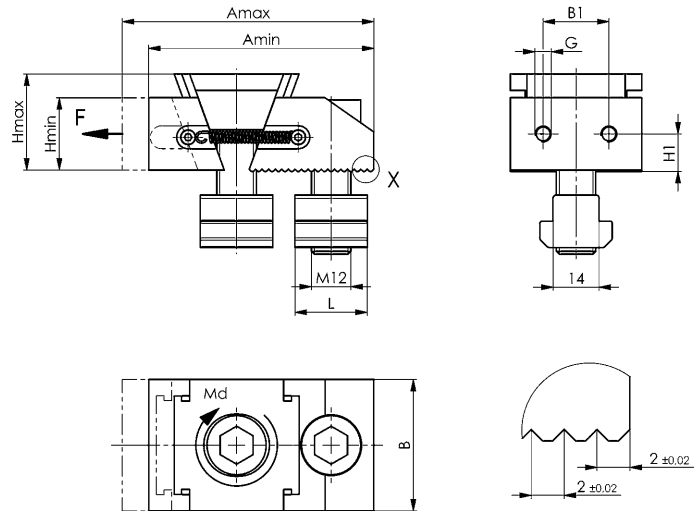
| Order no. | Size | A min. | A max. | B | B1 | G | H min. | H max. | H1 | L | Md max. | Clamping force F | Weight |
|-----------|------|--------|--------|----|----|----|--------|--------|------|----|---------|------------------|--------|
| | | | | | | | | | | | | [Nm] | [kN] |
| 429514 | 40 | 68,5 | 76,5 | 40 | 20 | M5 | 22 | 29,5 | 11,0 | 22 | 65 | 30 | 525 |
| 429530 | 72 | 65,0 | 76,0 | 72 | 36 | M6 | 29 | 39,5 | 14,5 | 22 | 65 | 30 | 1085 |

Design:

Material: case-hardened steel 21MnCr5
Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



No. 6376KKA

Wedge clamp with fixed jaw, claw jaws

For 5-axis clamp, 2 mm lower clamping step.
With fastening bolt and T-nut.



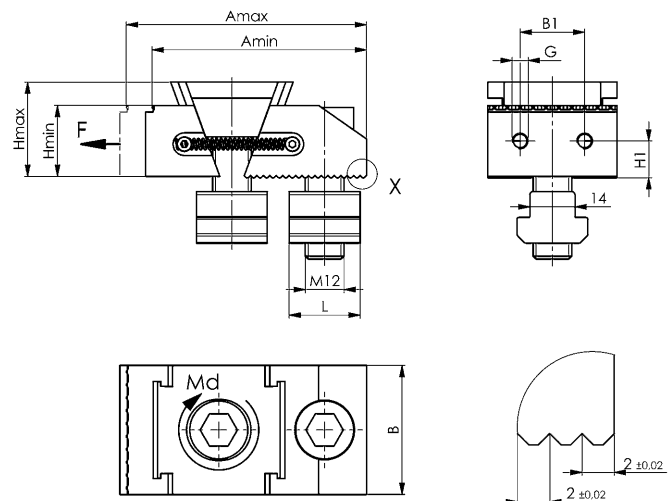
| Order no. | Size | A min. | A max. | B | B1 | G | H min. | H max. | H1 | L | Md max. | Clamping force F | Weight |
|-----------|------|--------|--------|----|----|----|--------|--------|------|----|---------|------------------|--------|
| | | | | | | | | | | | | [Nm] | [kN] |
| 429613 | 40 | 66,5 | 74,5 | 40 | 20 | M5 | 22 | 29,5 | 11,0 | 22 | 65 | 30 | 525 |
| 429639 | 72 | 63,0 | 74,0 | 72 | 36 | M6 | 29 | 39,5 | 14,5 | 22 | 65 | 30 | 1085 |

Design:

Material: case-hardened steel 21MnCr5
Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



No. 6376BA

Fixed clamping jaw, smooth

For 5-axis clamp.
With fastening bolt and T-nut.



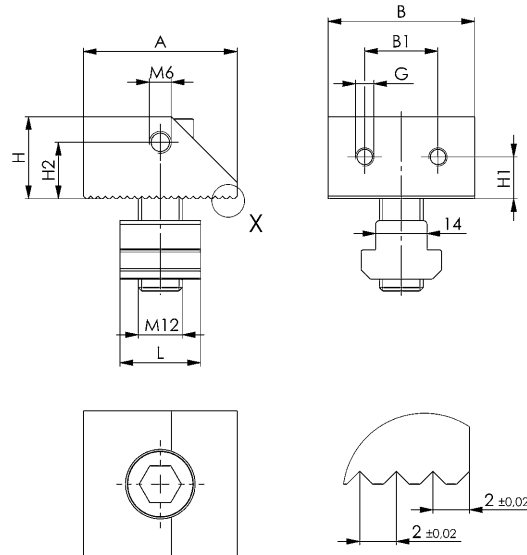
| Order no. | Size | A | B | B1 | G | H | H1 | H2 | L | Weight [g] |
|-----------|------|----|----|----|----|------|------|------|----|------------|
| 429555 | 40 | 42 | 40 | 20 | M5 | 22,4 | 11,4 | 15,4 | 22 | 280 |
| 429571 | 72 | 42 | 72 | 36 | M6 | 29,4 | 14,9 | 21,4 | 44 | 675 |

Design:

Material: case-hardened steel 21MnCr5
Highly tempered and case hardened to 52 HRC.
Hardness depth 0.6 mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the serration.
Workpieces can be positioned and clamped with great clamping force.



No. 6376BKA

Fixed clamping jaw with claw jaws

For 5-axis clamp, 2 mm lower clamping step.
With fastening bolt and T-nut.



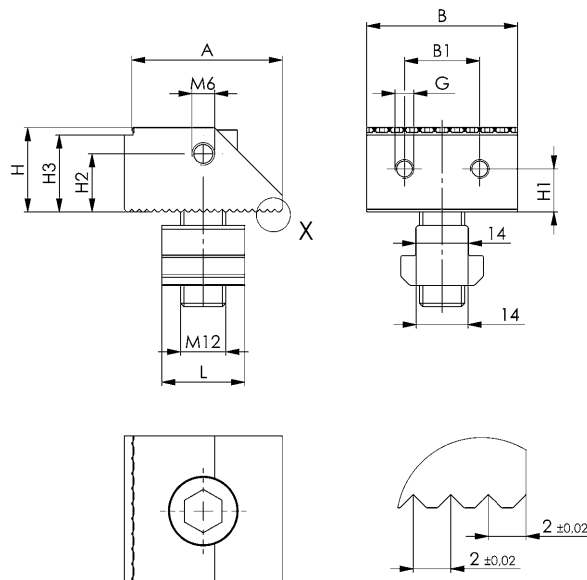
| Order no. | Size | A | B | B1 | G | H | H1 | H2 | H3 | L | Weight [g] |
|-----------|------|----|----|----|----|------|------|------|------|----|------------|
| 429654 | 40 | 40 | 40 | 20 | M5 | 22,4 | 11,4 | 15,4 | 20,4 | 22 | 278 |
| 429670 | 72 | 40 | 72 | 36 | M6 | 29,4 | 14,9 | 21,4 | 27,4 | 44 | 668 |

Design:

Material: case-hardened steel 21MnCr5
Highly tempered and case hardened to 52 HRC.
Hardness depth 0.6 mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the serration.
Workpieces can be positioned and clamped with great clamping force.



Subject to technical alterations.

No. 6540

Chain clamping set

Hook end and counterholder made of tempered steel, burnished.
Chain made of tempered steel.

Please order fastening for T-slots 6541 separately.

Consisting of:

- hook end
- protection set for clamp chain
- counterholder
- 4 roller chains
- 87601: 492 mm (2x), 238 mm (1x), 15.9 mm (1x)
- 87627: 991 mm (1x), 229 mm (1x), 483 mm (1x), 25.4 mm (1x)
- 4 locking links with cotter pins for connection
- 6 plastic protective elements
- open ring spanner 685Md



| Order no. | Slot | Screw G [mm] | Max. permissible torque Md [Nm] | Max. achievable clamping force F [kN] | Weight [g] |
|-----------|----------------|-----------------|------------------------------------|--|---------------|
| 87601 | 14, 16, 18 | M12 | 45 | 15 | 2628 |
| 87627 | 18, 20, 22, 24 | M16 | 90 | 40 | 7640 |

Application:

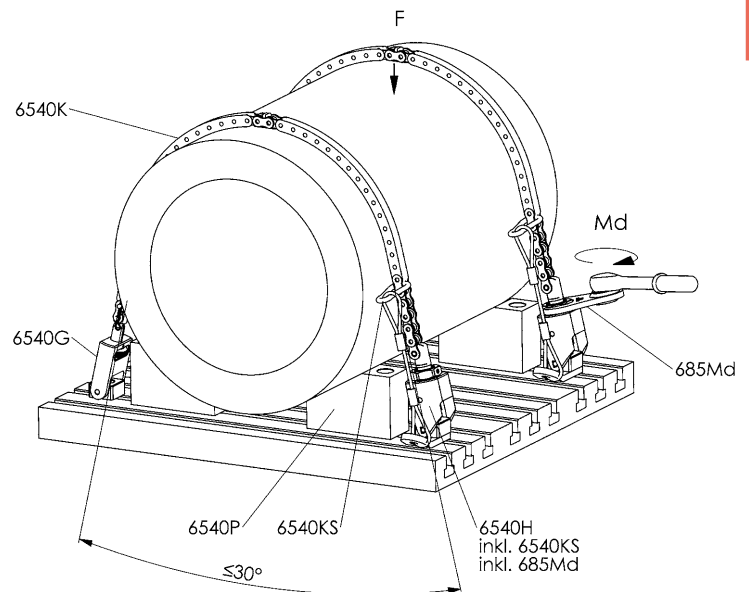
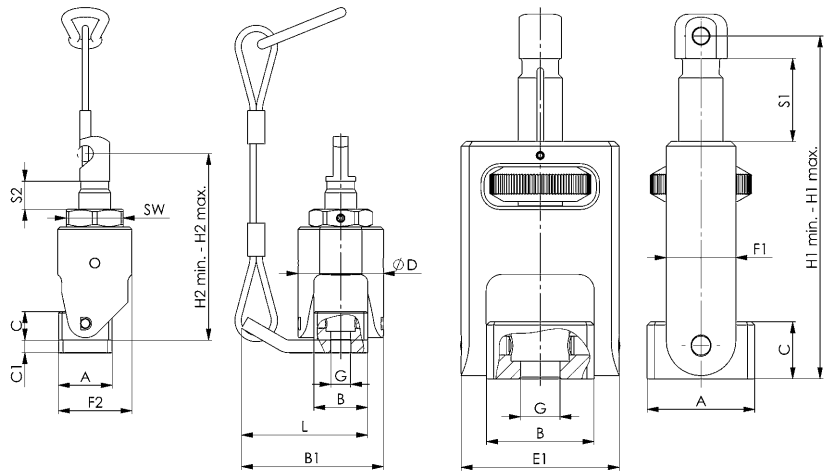
Mainly used for clamping cylindrical parts, such as valve bodies, flanges, pump housings, pistons etc. this device can be used both on machine tables and on clamping pallets. Initial selection of the chain length and setting clamping force is carried out at the take-up unit by turning the knurled nut. Finally, the torque necessary to generate clamping force is applied to the tensioning hook. Plastic pressure pads can be inserted in the chain links to protect the workpiece surface.

Advantage:

- Uniform pressure distribution reduces workpiece deformation.
- Workpiece can be protected by plastic pressure pads inserted in the chain links.
- Large range of adjustment (tensioning stroke) at take-up unit and tensioning hook.

Note:

Installation exclusively with the AMF fastening kit 6541 for hook ends and the protection set 6540K. For larger clamping tasks, the hook ends, counter catches and clamp chains of size 20 and 24 can be used.



Dimensions:

| Order no. | A | B | B1 | C | C1 | dia. D | E1 | F1 | F2 | H1 min. | H1 max. | H2 min. | H2 max. | Clamping stroke S1 | Clamping stroke S2 | L | SW |
|-----------|----|----|-----|----|----|--------|----|----|----|---------|---------|---------|---------|--------------------|--------------------|-----|----|
| 87601 | 34 | 34 | 90 | 18 | 8 | 54 | 50 | 21 | 47 | 83 | 108 | 100 | 118 | 25 | 18 | 80 | 36 |
| 87627 | 37 | 44 | 120 | 25 | 10 | 70 | 64 | 29 | 62 | 110 | 146 | 122 | 153 | 36 | 31 | 107 | 46 |

Subject to technical alterations.

No. 6540H

Hook end, mechanical

Tempered steel, burnished.

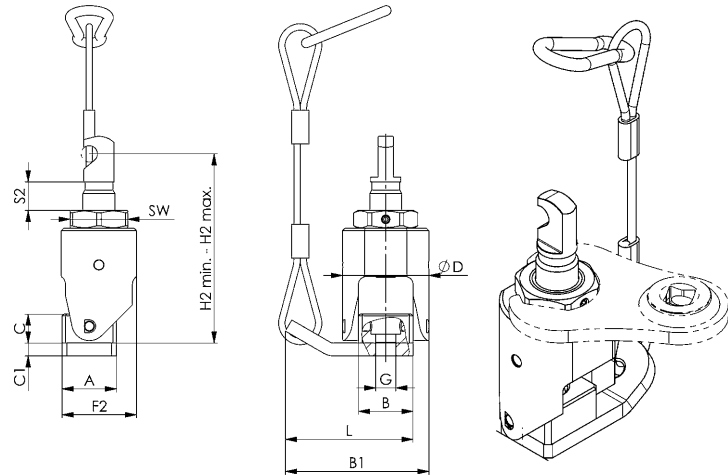
Including protection set 6540KS and corresponding ring spanner 685Md.



| Order no. | Size | Slot | G | max. permissible torque [Nm] | max. possible clamping force [kN] | SW | Weight [g] |
|-----------|------|----------------|-----|------------------------------|-----------------------------------|----|------------|
| 374934 | 12 | 14, 16, 18 | M12 | 45 | 15 | 36 | 853 |
| 374959 | 16 | 18, 20, 22, 24 | M16 | 90 | 40 | 46 | 1902 |
| 376517 | 20 | 22-28 | M20 | 190 | 75 | 65 | 6037 |
| 376533 | 24 | 28-36 | M24 | 300 | 120 | 65 | 6040 |

Note:

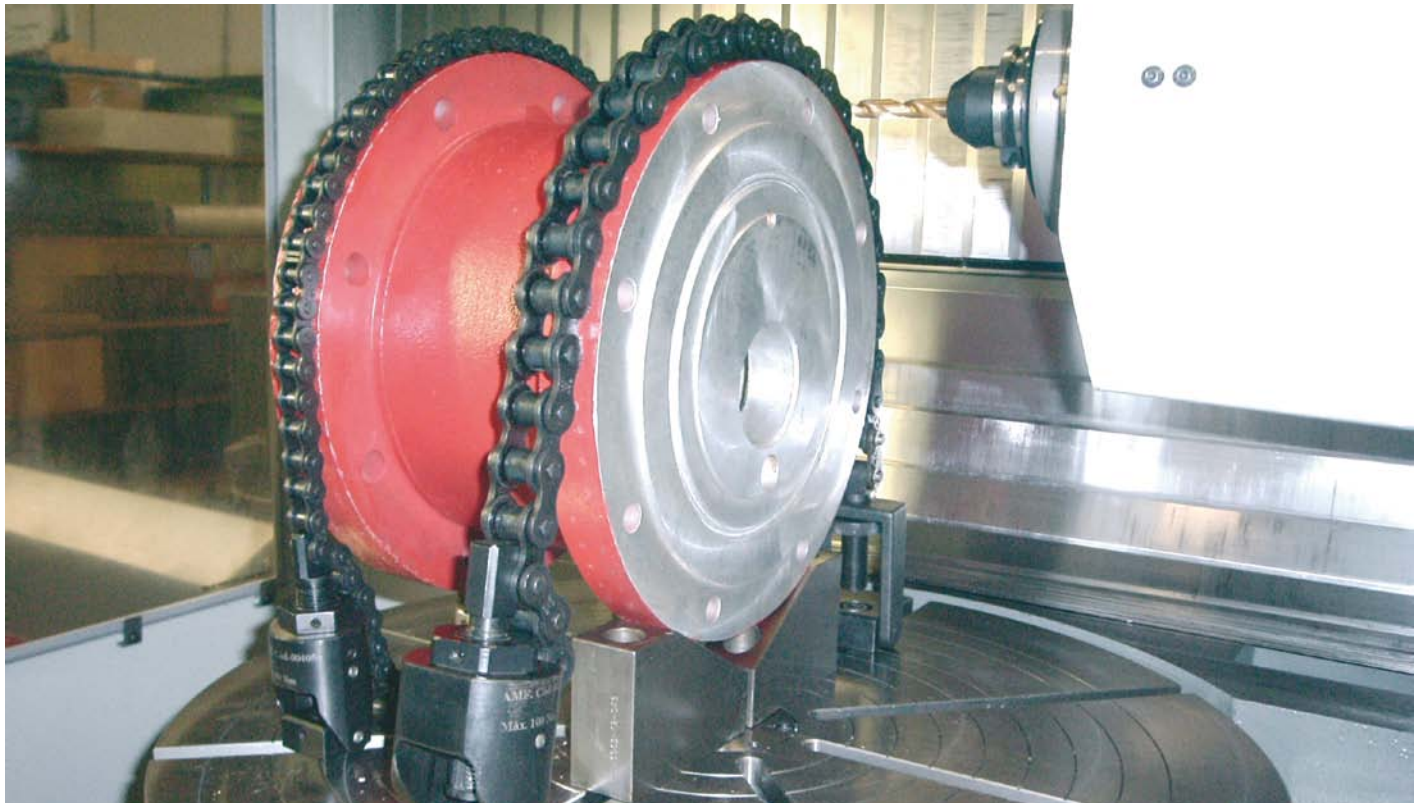
Installation exclusively with the AMF fastening kit 6541 for hook ends and the protection set 6540K.



Dimensions:

| Order no. | Size | A | B | B1 | C | C1 | dia. D | F2 | H2 min. | H2 max. | L | Clamping stroke S2 |
|-----------|------|----|----|-----|----|----|--------|----|---------|---------|-----|--------------------|
| 374934 | 12 | 34 | 34 | 90 | 18 | 8 | 54 | 47 | 100 | 118 | 80 | 18 |
| 374959 | 16 | 37 | 44 | 120 | 25 | 10 | 70 | 62 | 122 | 153 | 107 | 31 |
| 376517 | 20 | 58 | 64 | 151 | 41 | 10 | 98 | 86 | 195 | 250 | 134 | 55 |
| 376533 | 24 | 58 | 64 | 151 | 41 | 10 | 98 | 86 | 199 | 260 | 134 | 61 |

CAD

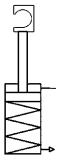


Subject to technical alterations.

No. 6926Z

Hook ends, hydraulic

max. operating pressure 400 bar.



| Order no. | Article no. | Slot | G | Stroke H [mm] | R | max. possible clamping force [kN] | Weight [g] |
|-----------|-------------|----------------|-----|---------------|------|-----------------------------------|------------|
| 325373 | 6926Z-12 | 14, 16, 18 | M12 | 20 | G1/4 | 13 | 1430 |
| 325399 | 6926Z-16 | 18, 20, 22, 24 | M16 | 30 | G1/4 | 39 | 3650 |
| 326959 | 6926ZL-16 | 18, 20, 22, 24 | M16 | 40 | G1/4 | 39 | 3950 |

Design:

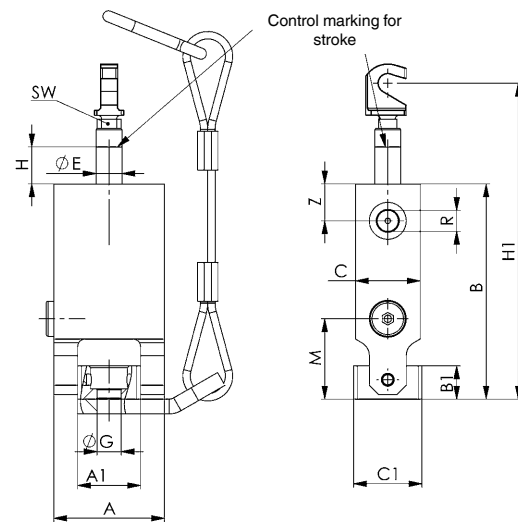
Cylinder barrel from steel, burnished. Piston and piston rod case hardened and ground. Wiper at piston rod. Piston rod with internal thread. Oil supply via threaded port.

Application:

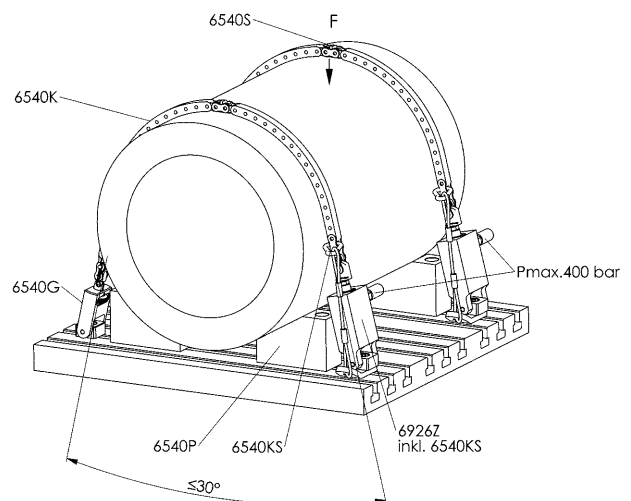
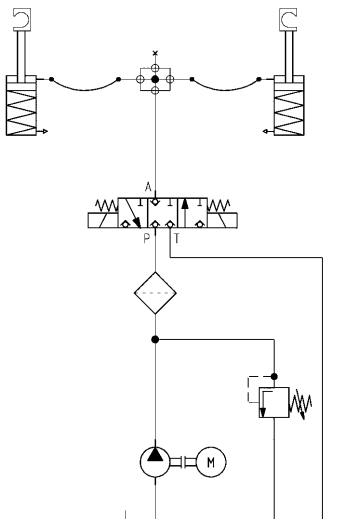
For tensioning primarily cylindrical parts - on both the machine table and clamping plates. The chain length and clamping force are preset on the counter catch using knurled nuts. The hook end is then placed under hydraulic pressure to tension the chain. The control marking on the piston rod marks the max. stroke and shows how far the hydraulic cylinder has been run out.

Advantage:

Even pressure distribution reduces workpiece deformation.



Hydraulic diagram:



Dimensions:

| Order no. | Article no. | A | A1 | B | B1 | C | C1 | dia. E | H1 | M | SW | Z |
|-----------|-------------|----|----|-------|----|----|----|--------|---------------|------|----|----|
| 325373 | 6926Z-12 | 60 | 34 | 116,5 | 18 | 35 | 37 | 14 | 151,5 - 171,5 | 43,5 | 10 | 20 |
| 325399 | 6926Z-16 | 75 | 44 | 154,0 | 25 | 55 | 37 | 20 | 188,0 - 218,0 | 54,0 | 17 | 25 |
| 326959 | 6926ZL-16 | 75 | 44 | 164,0 | 25 | 55 | 37 | 20 | 198,0 - 238,0 | 54,0 | 17 | 25 |



Subject to technical alterations.

No. 6540G

Counter catch

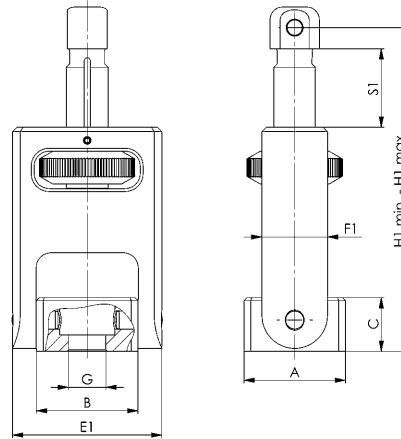
Tempered steel, burnished.



| Order no. | Size | Slot | Screw G [mm] | S1 Stroke [mm] | max. possible clamping force [kN] | Weight [g] |
|-----------|------|----------------|-----------------|-------------------|--------------------------------------|---------------|
| 374710 | 12 | 14, 16, 18 | M12 | 25,0 | 15 | 553 |
| 374728 | 16 | 18, 20, 22, 24 | M16 | 36,0 | 40 | 1235 |
| 376657 | 20 | 22-28 | M20 | 43,5 | 75 | 4088 |
| 376632 | 24 | 28-36 | M24 | 43,0 | 120 | 4145 |

Note:

Installation exclusively with the AMF fastening kit 6541 for counterholders.



Dimensions:

| Order no. | Size | A | B | C | E1 | F1 | H1 min. | H1 max. |
|-----------|------|----|----|----|----|----|---------|---------|
| 374710 | 12 | 34 | 34 | 18 | 50 | 22 | 83 | 108,0 |
| 374728 | 16 | 37 | 44 | 25 | 64 | 29 | 110 | 146,0 |
| 376657 | 20 | 58 | 64 | 41 | 91 | 48 | 162 | 205,5 |
| 376632 | 24 | 58 | 64 | 41 | 91 | 48 | 166 | 209,0 |

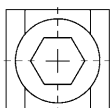
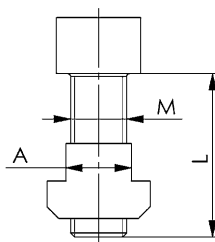
CAD



No. 6541

Fastening kit for hook end and counterholder

For attaching the chain clamping set no. 6540 on the subplate, composed of nut for T-nut, DIN 508 and screw complying with ISO 4762, class 8.8.



CAD



| Order no. | A | L 6540H [mm] | L 6540G [mm] | M | Weight [g] |
|-----------|----|-----------------|-----------------|-----|---------------|
| 84251 | 14 | - | 25 | M12 | 78 |
| 376483 | 14 | 35 * | - | M12 | 84 |
| 84269 | 16 | - | 30 | M12 | 95 |
| 376509 | 16 | 40 * | - | M12 | 113 |
| 84277 | 18 | - | 35 | M12 | 131 |
| 376525 | 18 | 40 * | - | M12 | 136 |
| 84285 | 18 | - | 35 | M16 | 168 |
| 376541 | 18 | 45 * | - | M16 | 184 |
| 84293 | 20 | - | 40 | M16 | 216 |
| 376566 | 20 | 50 * | - | M16 | 231 |
| 84343 | 22 | - | 45 | M16 | 290 |
| 376582 | 22 | 55 * | - | M16 | 305 |
| 84350 | 24 | - | 45 | M16 | 374 |
| 376608 | 24 | 55 * | - | M16 | 389 |
| 568518 | 22 | - | 55 | M20 | 376 |
| 568523 | 22 | 65 * | - | M20 | 401 |
| 568519 | 24 | - | 55 | M20 | 456 |
| 568524 | 24 | 70 * | - | M20 | 493 |
| 568520 | 28 | - | 65 | M20 | 601 |
| 568525 | 28 | 75 * | - | M20 | 625 |
| 568521 | 28 | - | 60 | M24 | 689 |
| 568526 | 28 | 70 * | - | M24 | 725 |
| 568522 | 36 | - | 70 | M24 | 1100 |
| 568527 | 36 | 80 * | - | M24 | 1125 |

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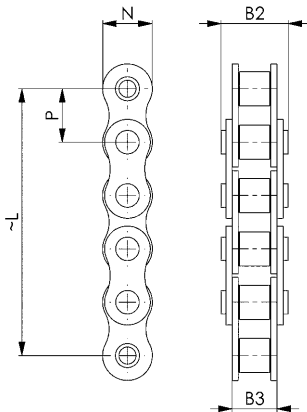
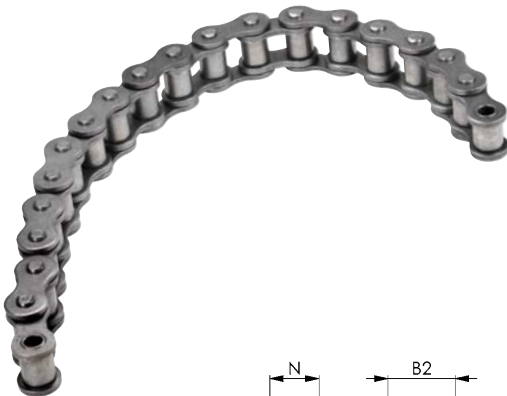
* For use of the protection set no. 6540KS

Subject to technical alterations.

No. 6540K

Roller chain

Single roller chain DIN 8187. ISO R 606 B, ST 37-2.
Surface: plain.



| Order no. | Size | Nominal size | L | B2 | B3 | N | P | max. possible clamping force [kN] | Weight [g] |
|-----------|------|--------------|------|----|----|----|--------|-----------------------------------|------------|
| 374736 | 12 | 125 | 111 | 20 | 13 | 15 | 15,875 | 15 | 114 |
| 374744 | 12 | 250 | 238 | 20 | 13 | 15 | 15,875 | 15 | 228 |
| 374751 | 12 | 500 | 492 | 20 | 13 | 15 | 15,875 | 15 | 455 |
| 374769 | 12 | 1000 | 1000 | 20 | 13 | 15 | 15,875 | 15 | 910 |
| 374777 | 16 | 125 | 127 | 23 | 25 | 21 | 25,400 | 40 | 335 |
| 374785 | 16 | 250 | 229 | 23 | 25 | 21 | 25,400 | 40 | 670 |
| 374793 | 16 | 500 | 483 | 23 | 25 | 21 | 25,400 | 40 | 1340 |
| 374801 | 16 | 1000 | 991 | 23 | 25 | 21 | 25,400 | 40 | 2680 |
| 376673 | 20 | 1000 | 984 | 44 | 29 | 26 | 31,750 | 75 | 3720 |
| 376699 | 20 | 1500 | 1492 | 44 | 29 | 26 | 31,750 | 75 | 5580 |
| 376715 | 20 | 2000 | 2000 | 44 | 29 | 26 | 31,750 | 75 | 7440 |
| 376723 | 24 | 1000 | 1028 | 54 | 38 | 33 | 38,100 | 120 | 7050 |
| 376749 | 24 | 1500 | 1485 | 54 | 38 | 33 | 38,100 | 120 | 10575 |
| 376764 | 24 | 2000 | 2019 | 54 | 38 | 33 | 38,100 | 120 | 14100 |

Application:

The individual chain lengths can be joined as required using the connecting links (No. 6540V). The chain can be shortened to any length as required.

Advantage:

- Chain can be extended or shortened to the required length with ease
- both sides usable with counter catches or hook ends
- resistant to temperature influences and soiling
- chains are tensioned to minimise elongation.

On request:

Customised lengths available!

No. 6540KS

Clamp chain protection set

Completely pre-assembled.



| Order no. | Size | Max. clamping force to be secured [kN] | A [mm] | dia. D [mm] | H [mm] | L [mm] | Weight [g] |
|-----------|------|--|--------|-------------|--------|--------|------------|
| 376111 | 12 | 15 | 34 | 13 | 8 | 80 | 280 |
| 376129 | 16 | 40 | 37 | 17 | 10 | 107 | 350 |
| 376491 | 20 | 75 | 58 | 21 | 10 | 134 | 1313 |
| 376558 | 24 | 120 | 58 | 25 | 10 | 134 | 1313 |

Application:

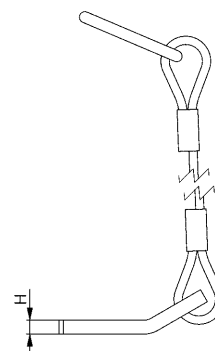
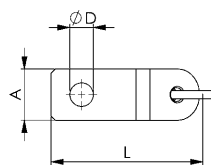
To use the clamp chain safely, the protection set is simply screwed below the hook end or the counterholder. Then, using the supplied connecting link, the protection set is fastened above the hook end. This prevents the clamp chain from snapping uncontrolledly if the hook end breaks.

Advantage:

- Easy mounting of the protection set
- Safe handling of the clamp chain
- Improved work safety.

Note:

If the protection set is damaged, the entire set must be replaced.



No. 6540P

Angle block, 120°

Tempered and burnished.



CAD



| Order no. | Size | 2R | B | B2 | F1 | F2 | G | H2 | H3 | H4 | L | L1 | L2 | L3 | L4 | dia. S | dia. S1 | Weight [g] |
|-----------|------|-----|----|----|----|-----|----|-----|-----|-----|-----|----|-----|----|-----|--------|---------|------------|
| 375568 | 12 | 80 | 47 | 20 | 27 | 67 | M6 | 80 | 35 | 5,5 | 118 | 19 | 59 | 42 | - | 13,5 | 20 | 3230 |
| 375584 | 16 | 100 | 47 | 20 | 33 | 33 | M6 | 100 | 44 | 5,5 | 148 | 24 | 74 | 44 | - | 17,5 | 26 | 3960 |
| 35121 | 20 | 270 | 78 | 20 | 91 | 161 | M6 | 250 | 102 | 5,5 | 360 | 45 | 100 | 44 | 160 | 22,0 | 33 | 32455 |
| 35162 | 24 | 270 | 78 | 20 | 91 | 161 | M6 | 250 | 102 | 5,5 | 360 | 45 | 100 | 44 | 160 | 26,0 | 40 | 31760 |

Advantage:

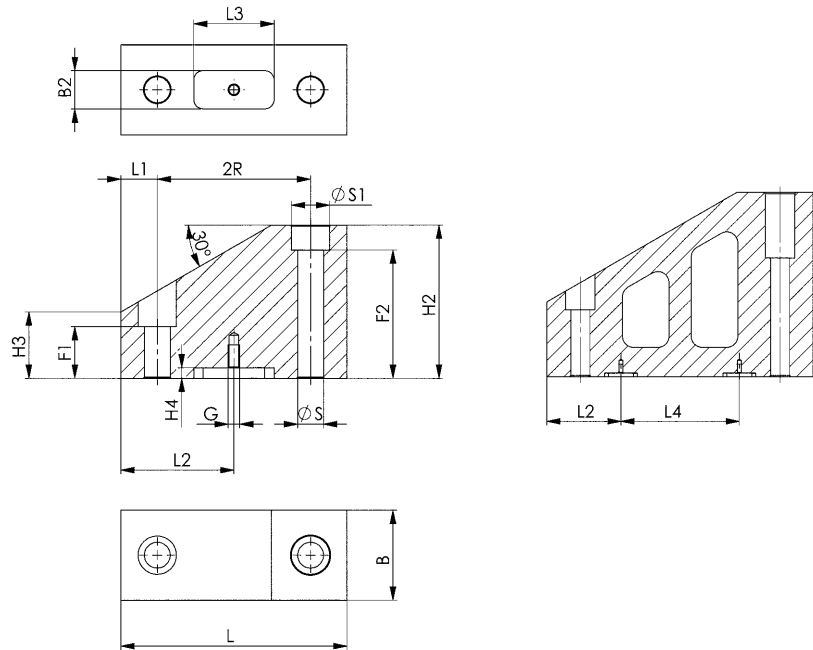
Optimised use of the clamp chain thanks to flexible positioning of the clamping prisms in the machine table groove.

Note:

The use of a flat T-nut no. 6322A or no. 6322B enables the clamping prisms to be precisely positioned in the machine table groove.

On request:

Special versions are available on request.



No. 6540F

Spring cotter pin

Packaging unit: 10 pcs.



| Order no. | Size | Packaging unit [St] | Weight [g] |
|-----------|------|---------------------|------------|
| 374835 | 12 | 10 | 0,5 |
| 374843 | 16 | 10 | 1,0 |
| 376822 | 20 | 10 | 2,2 |
| 376848 | 24 | 10 | 6,5 |

No. 6540S

Protective elements

for workpiece protection.

Packaging unit: 6 pcs.



| Order no. | Size | Packaging unit [St] | Weight [g] |
|-----------|------|---------------------|------------|
| 374850 | 12 | 6 | 3 |
| 374868 | 16 | 6 | 5 |
| 376574 | 20 | 6 | 10 |
| 376590 | 24 | 6 | 16 |

Application:

The protective elements are pushed into the gaps between the chain links.

Advantage:

The workpiece surface is protected.

Subject to technical alterations.

No. 6540V

Connecting links with spring cotter pin



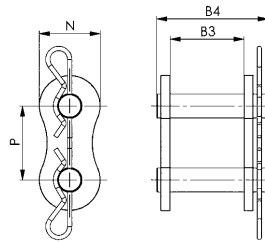
| Order no. | Size | B3 | B4 | N | P | max. possible clamping force [kN] | Weight [g] |
|-----------|------|----|----|----|--------|-----------------------------------|------------|
| 374819 | 12 | 13 | 22 | 14 | 15,875 | 15 | 15 |
| 374827 | 16 | 25 | 39 | 21 | 25,400 | 40 | 67 |
| 376780 | 20 | 29 | 44 | 26 | 31,750 | 75 | 113 |
| 376806 | 24 | 38 | 59 | 33 | 38,100 | 120 | 274 |

Application:

The connecting links are used for joining two chains together.

Advantage:

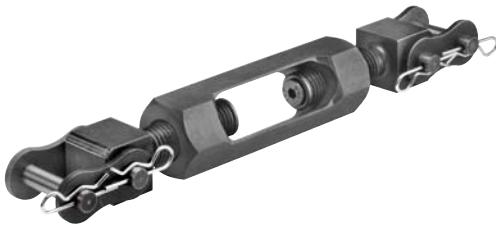
Chains simple and quick to combine and replace.



No. 6540VS

Turnbuckle included pre-installed locking links

Tempered steel, burnished.



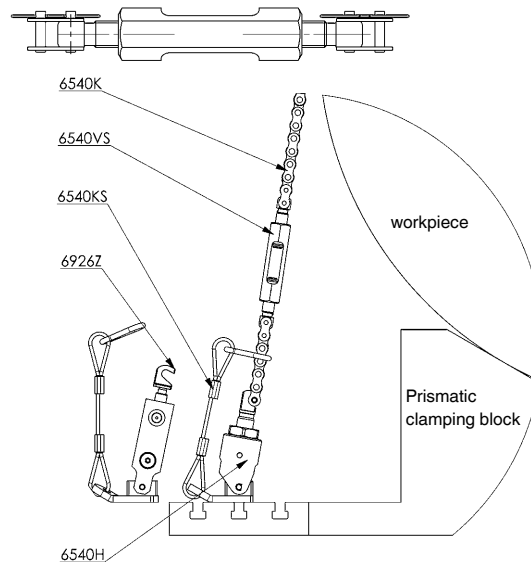
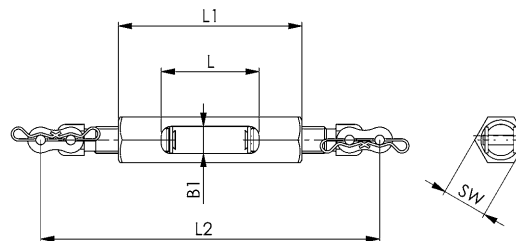
| Order no. | Size | L | L1 | L2 | B1 | SW | max. possible clamping force [kN] | Weight [g] |
|-----------|------|----|-----|-----------|----|----|-----------------------------------|------------|
| 376459 | 12 | 52 | 97 | 143 - 178 | 14 | 24 | 15 | 240 |
| 376616 | 16 | 65 | 126 | 202 - 253 | 20 | 30 | 40 | 720 |
| 551514 | 20 | 92 | 180 | 270 - 333 | 31 | 50 | 75 | 2222 |
| 551515 | 24 | 92 | 180 | 291 - 360 | 31 | 50 | 120 | 3517 |

Application:

The turnbuckle is clamped between the chains using two locking links. The chain is pretensioned through turning, and the play (caused by lengthening of the chain) is removed.

Advantage:

- Optimal application of pretensioning with use of long clamping chains (3 m or longer)
- Counteracting chain stretching for long chains



No. 685Md

Open ring spanner with torque-wrench fitting

Fits hook end 6540H.
 (AMF chain clamping set 6540)
 For hexagon clamping nuts.
 Drive 1/2" square socket with ball-engagement groove.
 Special steel, hardened and zinc-plated.



NEW!

| Order no. | SW | L | S | SW1 [inch] | T | T1 | Weight [g] |
|-----------|----|-----|-----|---------------|----|----|---------------|
| 52514 | 36 | 101 | 60 | 1/2 | 7 | 16 | 255 |
| 52522 | 46 | 107 | 60 | 1/2 | 8 | 16 | 330 |
| 568022 | 65 | 160 | 100 | 1/2 | 10 | 16 | 800 |

Advantage:

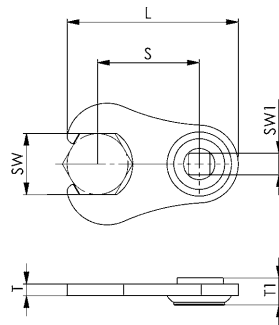
Ideally adapted for the controlled actuation of the hook end 6540 of the chain clamping set.

Note:

The set value for the torque wrench is dependant on insertion dimension „S“.
 The operating manual of your torque wrench contains the necessary specifications and calculation formulas.

Max. permissible tightening torque (Md max.) for use with the AMF chain clamping set 6540:

- 6540-12 - SW 36mm: 45 Nm
- 6540-16 - SW 46mm: 90 Nm
- 6540-20 - SW 65mm: 190 Nm
- 6540-24 - SW 65mm: 300 Nm



Subject to technical alterations.

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| No. 6375BI | 10 | No. 6376BG | 43 | No. 6376PB | 46 | No. 6540P | 58 | Nr. 6378A | 20 |
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| 265793 | 26 | 301200 | 33 | 304931 | 26 | 376699 | 57 | 429662 | 41 |
| 265835 | 27 | 301218 | 34 | 304949 | 24 | 376715 | 57 | 429670 | 52 |
| 266569 | 30 | 301234 | 34 | 304956 | 26 | 376723 | 57 | 429688 | 41 |
| 266577 | 31 | 301259 | 34 | 304964 | 24 | 376749 | 57 | 429696 | 44 |
| 266585 | 30 | 301275 | 34 | 304972 | 28 | 376764 | 57 | 429704 | 41 |
| 266593 | 31 | 301291 | 34 | 304998 | 28 | 376780 | 59 | 429712 | 44 |
| 266601 | 30 | 301317 | 34 | 305011 | 29 | 376806 | 59 | 430207 | 47 |
| 266619 | 31 | 301333 | 34 | 305037 | 29 | 376822 | 58 | 430223 | 47 |
| 266627 | 31 | 301358 | 34 | 305086 | 30 | 376848 | 58 | 52514 | 60 |
| 266635 | 31 | 301374 | 34 | 305094 | 30 | 428656 | 7 | 52522 | 60 |
| 266643 | 31 | 301390 | 34 | 325373 | 55 | 429035 | 38 | 545582 | 8 |
| 266650 | 31 | 301416 | 34 | 325399 | 55 | 429050 | 38 | 550278 | 6 |
| 266668 | 31 | 301432 | 34 | 326959 | 55 | 429076 | 38 | 550286 | 12 |
| 266676 | 31 | 301440 | 35 | 35121 | 58 | 429092 | 38 | 550287 | 12 |
| 266684 | 31 | 301465 | 35 | 35162 | 58 | 429118 | 38 | 551514 | 59 |
| 266700 | 31 | 301481 | 35 | 374710 | 56 | 429134 | 38 | 551515 | 59 |
| 266726 | 31 | 301507 | 35 | 374728 | 56 | 429175 | 45 | 567121 | 4 |
| 266742 | 31 | 301515 | 35 | 374736 | 57 | 429191 | 45 | 567122 | 4 |
| 266809 | 26 | 301523 | 35 | 374744 | 57 | 429217 | 46 | 567123 | 6 |
| 266825 | 27 | 301531 | 35 | 374751 | 57 | 429233 | 46 | 567124 | 6 |
| 266841 | 30 | 301549 | 35 | 374769 | 57 | 429258 | 46 | 567125 | 5 |
| 266866 | 30 | 301556 | 35 | 374777 | 57 | 429274 | 43 | 567126 | 5 |
| 266882 | 30 | 301564 | 35 | 374785 | 57 | 429290 | 43 | 567127 | 10 |
| 266908 | 31 | 301572 | 35 | 374793 | 57 | 429316 | 43 | 567128 | 10 |
| 290635 | 26 | 301580 | 34 | 374801 | 57 | 429332 | 43 | 567129 | 10 |
| 290650 | 26 | 301598 | 35 | 374819 | 59 | 429357 | 43 | 567130 | 10 |
| 295006 | 31 | 301606 | 34 | 374827 | 59 | 429365 | 43 | 568022 | 60 |
| 300863 | 28 | 301614 | 35 | 374835 | 58 | 429373 | 41 | 568438 | 18 |
| 300871 | 31 | 301622 | 34 | 374843 | 58 | 429381 | 43 | 568439 | 18 |
| 300889 | 28 | 301630 | 35 | 374850 | 58 | 429399 | 41 | 568440 | 20 |
| 300897 | 31 | 301648 | 34 | 374868 | 58 | 429407 | 43 | 568511 | 11 |
| 300905 | 27 | 301663 | 34 | 374934 | 54 | 429415 | 41 | 568512 | 11 |
| 300913 | 31 | 301689 | 34 | 374959 | 54 | 429423 | 44 | 568513 | 11 |
| 300921 | 27 | 301705 | 34 | 375568 | 58 | 429431 | 41 | 568514 | 11 |
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| 300947 | 30 | 301804 | 36 | 376111 | 57 | 429456 | 41 | 568519 | 56 |
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| 301044 | 30 | 304766 | 24 | 376533 | 54 | 429530 | 51 | 568527 | 56 |
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| 301069 | 31 | 304782 | 24 | 376558 | 57 | 429555 | 52 | 84269 | 56 |
| 301077 | 31 | 304790 | 24 | 376566 | 56 | 429563 | 40 | 84277 | 56 |
| 301085 | 33 | 304808 | 24 | 376574 | 58 | 429571 | 52 | 84285 | 56 |
| 301101 | 33 | 304816 | 24 | 376582 | 56 | 429589 | 40 | 84293 | 56 |
| 301127 | 33 | 304824 | 24 | 376590 | 58 | 429605 | 40 | 84343 | 56 |
| 301143 | 33 | 304840 | 24 | 376608 | 56 | 429613 | 51 | 84350 | 56 |
| 301168 | 33 | 304873 | 24 | 376616 | 59 | 429621 | 40 | 87601 | 53 |
| 301176 | 34 | 304899 | 24 | 376632 | 56 | 429639 | 51 | 87627 | 53 |
| 301184 | 33 | 304915 | 24 | 376657 | 56 | 429647 | 40 | | |
| 301192 | 34 | 304923 | 24 | 376673 | 57 | 429654 | 52 | | |

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These Terms of Payment apply for companies, legal entities governed by public law and public law special funds. Our goods and services are supplied exclusively on the basis of the following conditions. Any deviating purchasing conditions of the customer not expressly recognised by us will not become part of the contract through acceptance of the order. By placing the order and accepting the goods we deliver, the customer confirms its consent to our terms and conditions.

1. Offer and contractual conclusion

All our offers are always subject to change without notice unless otherwise explicitly agreed. Our delivery contracts are based on the latest version of our catalogue. Dimension and weight values, as well as illustrations, drawings and data, are non-binding and can be changed by us at any time. Therefore, deviations cannot be ruled out and do not justify any compensation claims against us.

Orders are considered accepted only when confirmed by us in writing. If, for organisational reasons, the customer does not receive a separate confirmation upon the delivery of goods, the invoice shall also be deemed the order confirmation.

2. Prices

The prices are in EURO, ex-works, excluding VAT, packing, freight, postage and insurance. Unless otherwise agreed, our list prices valid on the day of delivery shall apply. For orders below 50 EUR goods net, we must make a minimum quantity surcharge of a 20 EURO for cost reasons.

3. Tool costs

Unless any other agreements have been reached, the tools fabricated for the purpose of executing the order shall remain our property in all cases, even if we have invoiced a tool cost component separately.

4. Payment

Unless otherwise stated on the invoice, the purchase price falls due for net payment within 30 days of the invoice date (without deduction of discount). Invoice amounts of below 50 EURO are due for payment immediately.

In case of payment default, we shall be entitled to charge default interest. The amount corresponds to our interest rate for current account credits at our main bank; the minimum however being 8 percentage points above the relevant base interest rate applied by the European Central Bank. Moreover, in case of default following written notice to the customer, we shall be entitled to cease to fulfil our obligations until payments are received.

5. No set-off

The customer can set-off only with legally confirmed or undisputed counterclaims.

6. Right of withdrawal in case of delayed acceptance or payment and insolvency

If the customer fails to accept the goods in due time, we shall be entitled to set a reasonable period of grace, after which we can dispose of the goods elsewhere and supply the customer on a reasonably longer term. Our rights to withdraw from the contract under the provisions of Section 326 BGB and demand damages for non-performance shall not be affected. If the customer fails to pay for the goods once payment is due, we shall be entitled, at the end of a reasonable period of grace we have set, to withdraw from the contract and demand the return of any goods already supplied. Section 323 BGB remains unaffected in all other cases.

If the customer applies for the opening of insolvency proceedings, we shall be entitled, prior to the ordering of security measures by the insolvency court, to withdraw from the contract and demand the immediate return of the goods.

7. Customer-specific fabrications/project fabrications (custom fabrications)

Customer-specific fabrications require binding information on design, quantity etc. in written form at the time of ordering. For manufacturing reasons, we reserve the right to supply up to 10% above or below the order quantity. Technical modifications or cancellations are subject to any costs incurred. The return of customer-specific fabrications is impossible.

8. Delivery and packaging, transfer of risk

The delivery date is non-binding; although stated to the best of our knowledge. It is subject to us receiving correct, defect-free and complete deliveries. The stated delivery dates relate to completion in the factory, starting on the day the order is accepted by us. Delivery is EXW (ex-works) in accordance with Incoterms 2010. Therefore, the costs are borne by the customer. The risk is transferred to the customer when the goods are passed to the person, company or facility nominated to execute the shipment. This applies also for partial deliveries, or if we have assumed responsibility for delivery and installation. The risk shall be transferred to the customer even in the case of delayed acceptance.

In the absence of specific shipping instructions, we shall proceed as we deem fit and without any obligation to the cheapest or most expedient method. The customer agrees that the order can also be delivered in parts, insofar as this is reasonable for the customer. We shall charge a 5 EURO processing free for shipping to third parties that we supply on behalf of the customer.

The packaging complies with the packaging ordinance. Disposable packaging shall be charged at cost price. The packaging cannot be taken back.

9. Performance impediment and/or impossibility

If we are hindered in the fulfilment of our obligation due to the onset of unforeseeable circumstances, which we are unable to avoid despite reasonable effort in relation to the nature of the circumstances (e.g. operational interruption, delay in the delivery of important raw materials, defects in the delivery), the delivery time shall be extended by a reasonable period, insofar as the supply of goods or services is not rendered unreasonably difficult or impossible.

If we have to accept that these circumstances are not only temporary, we shall be entitled to withdraw from the contract either in whole or in part.

If the supply of goods or services becomes impossible, the customer shall not be obliged to furnish its own contractual service. Section 275 BGB applies mutatis mutandis. If, however, the customer is solely or predominantly responsible for the

circumstances that led to impossibility, it shall remain under an obligation to render the return service. The same applies if this circumstance occurs at a time when the customer is behind schedule with acceptance.

10. Samples/returns

Samples shall be provided only against payment. If samples or models are provided, a credit note shall be issued with the subsequent order if the order value is 125 EURO net or more. Goods can be returned only by agreement, although custom fabrications are excluded from such return.

In the case of returns for which we are not responsible (e.g. incorrect order), we shall charge a processing fee of 10%, the minimum value, however, being 7.50 EURO.

11. Retention of title

The goods shall remain our property unless full payment of all claims and/or until the cheques provided for this purpose are honoured. The itemisation of claims in an ongoing invoice, as well as balancing the account and the recognition thereof does not affect the retention of title. The customer is entitled to sell on the retained goods during the ordinary course of business. However, the customer is not permitted to pledge the goods or transfer them by way of security. It shall assign its claim ensuing from the selling on of the retained goods to us in advance. The customer shall be entitled to collect the claim to the extent that it has fulfilled its obligations towards us. At our request, the customer shall be obliged to state third-party debtors and we shall be entitled to report this and the assignment.

12. Property rights

We reserve property rights and copyrights to all contractual documents such as drafts, drawings, calculations and cost estimates. Such documents must not be reproduced or disclosed to third parties without our consent. Any rights to patents, utility models etc. reside solely with us, insofar as such patents have not yet been filed. Our products are allowed to be replicated only with our written consent.

If objects are fabricated according to drawings or samples, the customer shall warrant that any third party property rights are not infringed by manufacture or delivery. If a third party forbids manufacture and delivery on account of property rights, we shall be entitled to stop manufacture and delivery immediately. The customer shall be obliged to reimburse us with all costs incurred and indemnify us from third party compensation claims. Compensation claims by the customer are impossible.

13. Warranty

If the customer agrees with us a particular quality of the goods, we shall base this agreement on our technical delivery specifications. If we have to deliver according to customer drawings, specifications, samples etc., the customer shall assume the risk for suitability for the intended purpose. If, after the contract is concluded, the scope of goods or services is changed at the customer's request and this impairs the quality or suitability of the goods, claims for defects on the part of the customer shall be ruled out, insofar as such impairments are caused by the customer's requests for change. The time at which the risk is transferred is decisive for the contractual state of the goods. Wear and tear of wearing parts caused by ordinary use does not constitute a defect. Claims for defects are ruled out in the following cases in particular: Unsuitable or improper use, incorrect installation and/or commissioning by the customer or third party, normal wear and tear, incorrect or negligent handling - in particular excessive use -, unsuitable equipment, replacement materials, chemical, electrochemical or electrical influences, unless such defects are caused by ourselves.

If the goods contain a defects, we shall provide, following a reasonable period of grace set by the customer, either a replacement or a repair as we deem fit. If such subsequent performance fails, the customer shall be entitled to either reduce the purchase price or withdraw from the contract. Any further warranty claims are ruled out. In case of negligible deviations from the agreed quality, no claims for defects shall be recognised.

The discovery of defects must be communicated to us immediately in writing. In the case of recognisable defects, however, within 10 days of acceptance, in the case of non-recognisable defects immediately after they become evident. The warranty is 12 months, starting with delivery of the goods ex-works.

14. Liability

With the exception of harm to life, body or health on account of a breach of duty by ourselves, our liability shall be limited to intent or gross negligence.

15. Place of fulfilment, place of jurisdiction and governing law

The place of fulfilment for all obligations ensuing from this contractual relationship is D-70734 Fellbach.

The place of jurisdiction for all legal disputes ensuing from the contractual relationship is the court responsible for the headquarters of Andreas Maier GmbH & Co. KG.

All disputes ensuing from the contract or regarding the validity thereof shall be finally decided by a court of arbitration in accordance with the Court of Arbitration Ordinance of the German Committee for Arbitration Court Procedures or the Conciliation and Arbitration Arrangement of the International Chamber of Commerce, recourse to ordinary courts of law being excluded. The legal dunning process, however, remains permissible.

German law shall govern (BGB and HGB). The applicability of the UN Convention on Contracts for the International Sale of Goods (CISG) is ruled out.

16. Severability clause

If individual provisions become legally invalid, the remaining provisions shall not be affected. The legally invalid provision shall be replaced by regulations that most closely reflect the economic purpose of the contract with reasonable consideration for the mutual interests. The publication of these Terms of Sale, Delivery and Payment renders all previous versions invalid. This does not apply for any contracts concluded prior to announcement.

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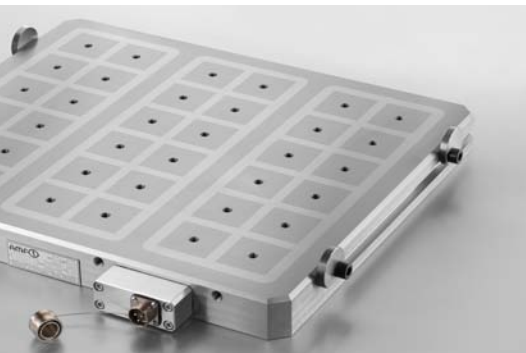
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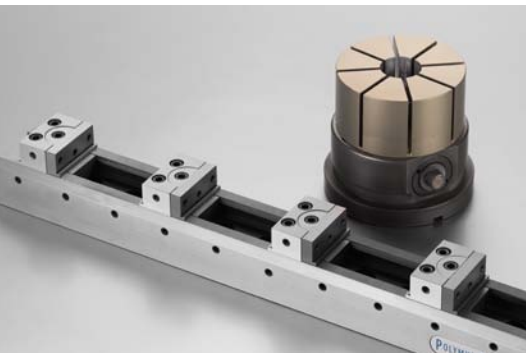
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